14" ULTIMATE BANDSAW

MODEL G0555

INSTRUCTION MANUAL

ONLINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE . CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the equipment or property damage hazards.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning *ON*.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT.** Do not use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE MACHINE.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.

⚠WARNING
Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	25ft	50ft	100ft
0-6	18	16	16
7-10	18	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.

13. **DO NOT OVERREACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

17. **MANY WOODWORKING TOOLS CAN "KICKBACK" THE WORKPIECE** toward the operator if not handled properly. Know what conditions can create "kickback" and know how to avoid them. Read the manual accompanying the machine thoroughly.

18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

20. **NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

21. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

⚠WARNING

Additional Safety Instructions For Bandsaws

1. **DO NOT OPERATE WITH DULL OR BADLY WORN BLADES.** Dull blades require more effort to use and are difficult to control. Inspect blades before each use.

2. **NEVER POSITION FINGERS OR THUMBS IN LINE WITH THE CUT.** Serious personal injury could occur.

3. **DO NOT OPERATE THIS BANDSAW WITHOUT WHEEL, PULLEY, AND BLADE GUARDS IN PLACE.**

4. **WHEN REPLACING BLADES,** make sure the teeth face down toward the table. The force of the cut is always down. Make sure the blade is properly tensioned.

5. **CUTS SHOULD ALWAYS BE FULLY SUPPORTED** by the table or some type of support fixture. Always support round stock in a V-block.

6. **DO NOT BACK WORKPIECE AWAY** from the blade while the saw is running. Plan your cuts so that you always cut out of the wood. If you need to back the work out, turn the bandsaw off and wait for the blade to come to a complete stop. DO NOT twist or put excessive stress on the blade while backing work away.

7. **ALWAYS FEED STOCK EVENLY AND SMOOTHLY.** DO NOT force or twist blade while cutting, especially when sawing small radii.

8. **THIS MACHINE IS NOT DESIGNED TO CUT METAL** or other material except wood.

9. **BLADE SHOULD BE RUNNING AT FULL SPEED** before beginning a cut.

10. **DO NOT MANUALLY STOP OR SLOW BLADE** after turning the saw off. Allow it to come to a complete stop before you leave it unattended.

11. **ALL INSPECTIONS, ADJUSTMENTS, AND MAINTENANCE ARE TO BE DONE WITH THE POWER OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.

12. **HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.

13. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.

⚠WARNING

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use the Model G0555 will be time well spent. DO NOT operate this machine until you are completely familiar with the contents of this manual or serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment or poor work results.

SECTION 2: GENERAL INFORMATION

Commentary

Grizzly Industrial, Inc. is proud to offer the Model G0555 14" Ultimate Bandsaw. This bandsaw is part of Grizzly's growing family of fine woodworking machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation, and proof of Grizzly's commitment to customer satisfaction.

The Model G0555 features a deluxe heavy-duty stand, upper and lower ball bearing guides, a 2" dust port, 1500 and 3200 FPM blade speeds, a 14" x 14" precision ground cast iron table, deluxe extruded aluminum fence with magnifying window, a miter gauge, and computer balanced cast aluminum wheels.

Specifications include a 1 HP 110/220V single-phase motor, a 13⅜" cutting throat capacity, a 6" maximum cutting height capacity, a 43⅝" floor to table height, a 45° right and 10° left table tilting capacity, cast iron frame construction, a 92½" blade length capacity, a ⅛" to ¾" blade width capacity, and an overall size of 66½"H x 26⅜"W x 20½"D.

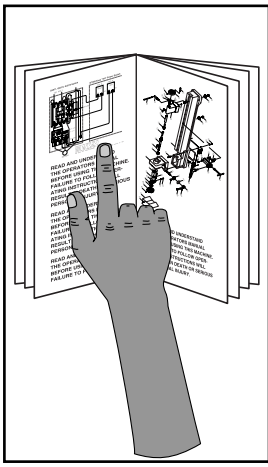
We are also pleased to provide this manual with the Model G0555. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any comments or criticisms that you feel we should address in our next printing, please write to us at:

Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227

Most important, we stand behind our machines. We have excellent regional service departments at your disposal should the need arise. If you have any service questions or parts requests, please call or write to us at the location listed below.

Grizzly Industrial, Inc
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone:(570) 546-9663
Fax:(800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

The specifications, drawings, and photographs illustrated in this manual represent the Model G0555 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.



⚠WARNING

Serious personal injury may result if safety or operational information is not understood or followed. Read the manual before assembly and operation to become familiar with the machine and its operation before beginning any work.

SECTION 3: CIRCUIT REQUIREMENTS

110V Operation

The Model G0555 motor is prewired to operate at 110V, and includes a plug (similar to the illustration in **Figure 1)** that has a ground prong and two current carrying prongs. The plug should only be placed into a grounded outlet box similar to the one illustrated in **Figure 1**. Make sure the outlet that you plug into is properly installed and grounded in accordance with all local codes and ordinances.

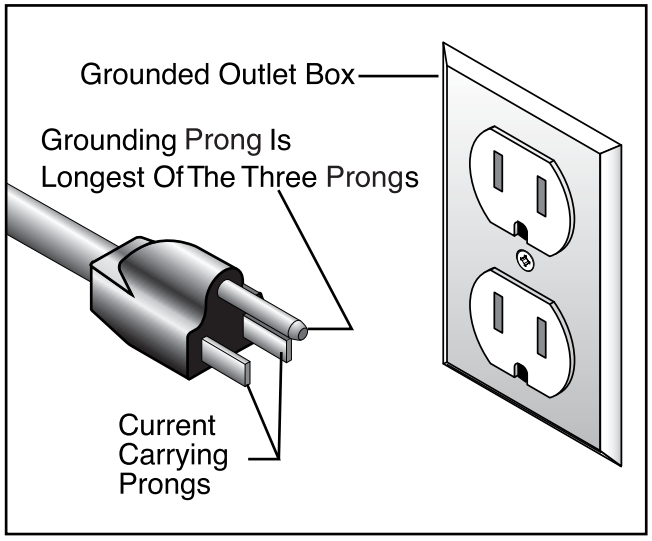


Figure 1. Typical 110V 3-prong plug and outlet.

Under normal 110V use, the motor draws approximately 10 amps. We recommend a 15 amp circuit breaker or a 15 amp slow-blow fuse.

We also recommend that the circuit you use should be dedicated, (i.e., the G0555 should provide the only draw from that circuit). If frequent circuit failures occur when using the bandsaw, contact our Service Department or your local electrical contractor.

220V Operation

The Model G0555 motor can be wired to single-phase 220V. Under normal use, the motor draws approximately 5 amps at 220V. We recommend a 10 amp circuit breaker for 220V operation. This should be satisfactory for normal use while providing enough protection for the circuits. Also, be sure the wires in your circuit are rated for at least 10 amp service.

This machine does not come supplied with a 220V plug, therefore a suitable 220V plug must be wired in. When operating at 220V, we recommend using a NEMA-style 6-15 plug and outlet. **See Figure 1A**. You may also “hard-wire” the machine directly to your panel, provided you place a disconnect switch near the machine. Check the electrical codes in your area for specifics on wiring requirements.

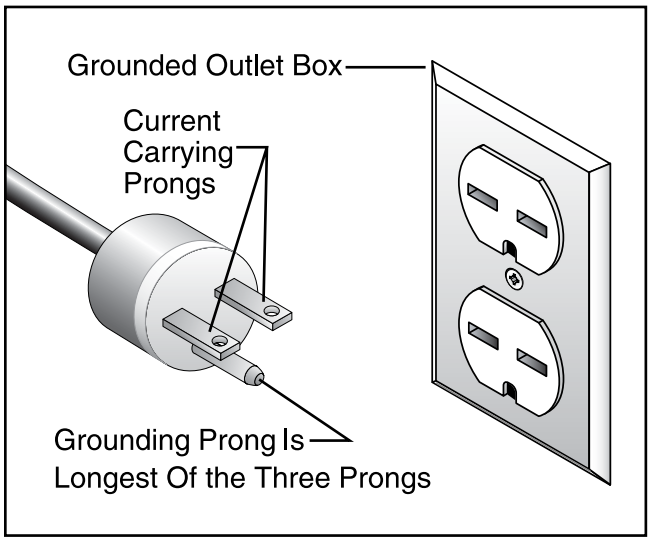
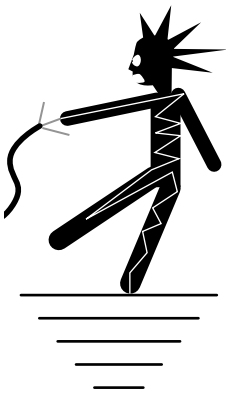


Figure 1A. NEMA 6-15 220V plug and outlet.

Grounding

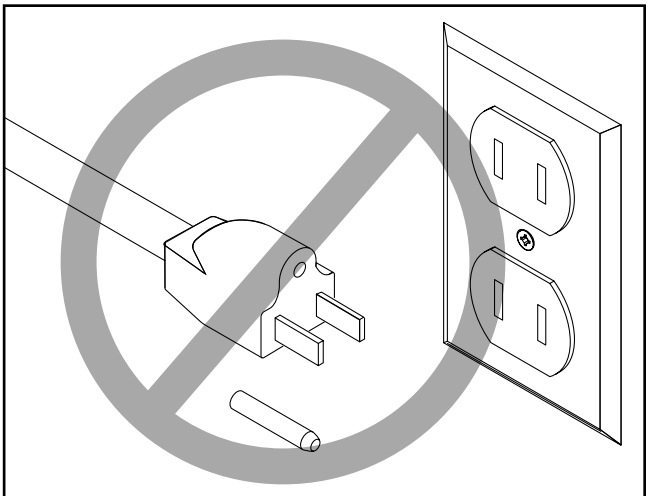


⚠WARNING

Electrocution or fire may result if this machine is not grounded correctly. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. DO NOT use the machine if it is not grounded.

In the event of a malfunction or breakdown, grounding provides electric current a path of least resistance to reduce the risk of electric shock.

This tool is equipped with an electric cord having an equipment grounding conductor. Improper connections of the electrical-grounding conductor can result in the risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.



⚠CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. DO NOT remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Check with a qualified electrician or one of our service personnel if the grounding instructions are not completely understood, or if you are in doubt as to whether the tool is properly grounded.

Extension Cords

If you find it necessary to use an extension cord with this machine:

- Only use a cord that is rated for hard service (Grade S).
- Only use a cord that contains a grounding prong.
- Use at least a 16 gauge cord if the cord is 50 feet long or less.
- Use at least a 14 gauge cord if the cord is between 50-100 feet.
- Always repair or replace cords when they become worn or damaged.

⚠CAUTION

We have covered some basic electrical requirements for the safe operation of your bandsaw. These requirements are not necessarily comprehensive. You must be sure that your particular electrical configuration complies with local and state codes. Ensure compliance by checking with your local municipality or a licensed electrician.

SECTION 4: MACHINE FEATURES

Bandsaw Features

To help you understand the set up and operation instructions, become familiar with the basic features of your new bandsaw.

Match up the list below with the letters in **Figures 2 & 3** to identify the bandsaw features and controls.

A. ON/OFF Switch — Makes the machine run or stop, but does not cut power to the machine and should never be substituted for unplugging the power when required.

B. Fence Lock Handle — Locks the fence in place for cutting operations and unlocks the fence for adjustments or removal.

C. Hinged Wheel Covers — Allows wheels and pulleys to be easily accessed for maintenance, blade changes or adjustments.

D. Blade Guide Assemblies — Two assemblies, 1 upper and 1 lower, each consisting of 2 roller bearing blade guides for side-to-side support and 1 roller bearing to support the back of the blade.

E. Table Trunnion Adjustment Knobs — Loosens the table on the trunnions for tilt adjustments and locks the table in place at a desired angle.

F. Table Tilt Scale — Displays the current angle of table tilt.

G. Quick Blade Tension Lever — Quickly releases or engages blade tension for blade changes.

H. Blade Tension Adjustment Knob — Controls minor/moderate blade tension adjustments.

I. Blade Tracking Adjustment Knob — Controls the tilt angle of the upper wheel, which defines how the blade will track on the wheel.

J. Guide Post Lock Knob — Loosens the guide post for adjustments and locks the guide post in place after adjustments.

K. Blade Tension Scale — Displays the current blade tension and is marked with a scale for a range of blade sizes.

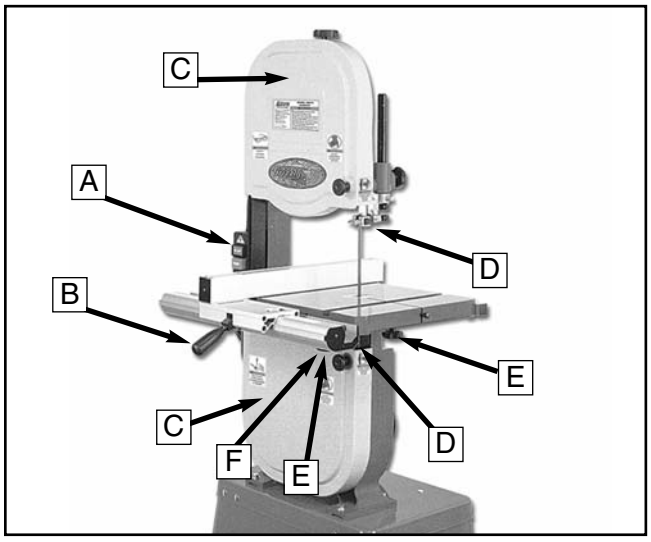


Figure 2. Front view of bandsaw.

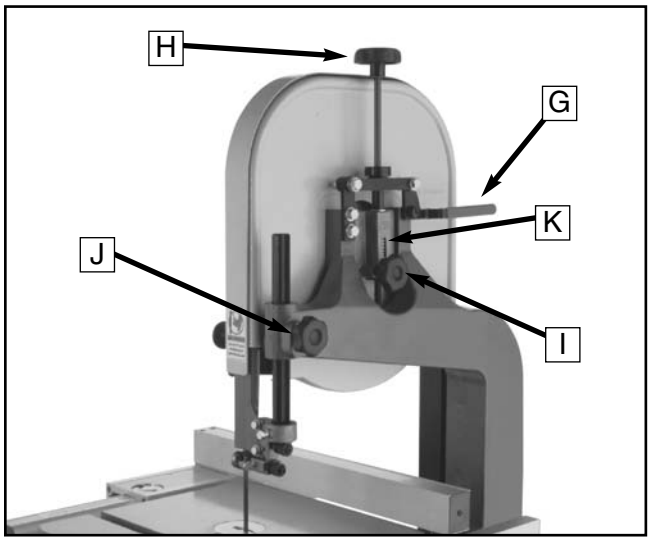


Figure 3. Rear view of bandsaw.

SECTION 5: SET UP

Unpacking

The Model G0555 Bandsaw is shipped from the manufacturer in 2 carefully packed cartons. If you discover the machine is damaged after you have signed for delivery, *please call Customer Service immediately for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise filing a freight claim can be difficult.* When you are completely satisfied with the condition of your shipment, you should inventory its parts.

⚠CAUTION

The Model G0555 weighs approximately 167 lbs. when fully assembled. DO NOT over-exert yourself while unpacking or moving your machine – get assistance.

⚠CAUTION

Some metal parts may have sharp edges that can cause minor injury. Please examine the edges of all metal parts BEFORE handling them and be careful WHILE handling them.

Piece Inventory

After you remove the items from **Box 1**, you should have:

	QTY
Bandsaw Unit	1
Table	1
Trunnion Support	1
Stand Top	1
Stand Top Braces	2
Stand Sides	2
Lower Stand Braces	2
Upper Stand Braces	2
Knobs	2
Miter Gauge	1
Hardware Bags:	
— Hex Bolt M8-1.25 x 35	4
— Flat Washer 8MM	8
— Lock Washer 8MM	6
— Hex Nut M8-1.25	5
— Hex Bolt M8-1.25 x 30	2
— Hex Bolt M8-1.25 x 80	1
— Carriage Bolt M8-1.25 x 16	8
— Flange Nut M8-1.25	8
— Hex Bolt M6-1.0 x 16	16
— Flat Washer 6MM	16
— Flange Nut M6-1.0	16
— Stand Foot	4
— Hex Nut ⅜"-16	8
— Flat Washer M10	8

Figures 4 and 5 on the next page show the items from **Box 1**.

Figure 4. Bandsaw unit from Box 1.

Figure 5. Bandsaw components from Box 1.

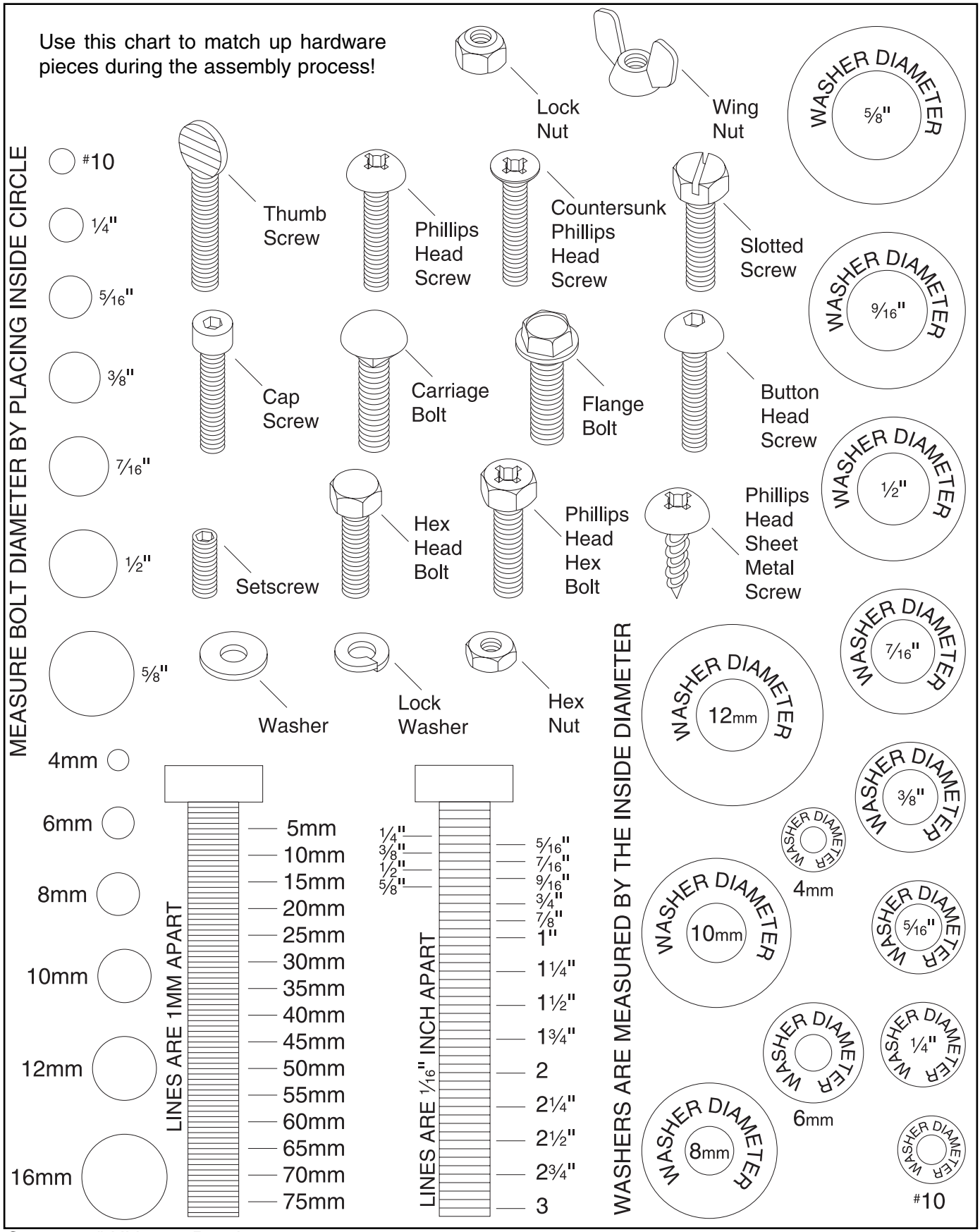
After you remove the items from **Box 2**, you should have:

Fence 1
Large Fence Rail 1
Small Fence Rail 1
Hardware Bag:
- — Fence Lock Handle M8 1
- — Cap Screw M6 x 16 2
- — Hex Bolt M6 x 20 2
- — Lock Washer M6 2
- — Hex Nut M8 1
- — Flat Washer M6 2

Figure 6. Fence components from Box 2.

In the event that any non-proprietary parts are missing (e.g. nuts or washers), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

Hardware Recognition Chart



Clean Up

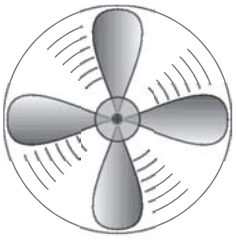
The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

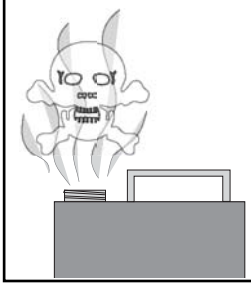
⚠WARNING

Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used.

⚠WARNING

Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.





⚠CAUTION

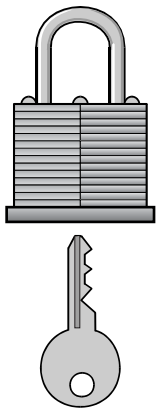
Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.

Site Considerations

- **Floor Load:** Your Model G0555 14" Ultimate Bandsaw represents a moderate weight load in a small footprint. Most commercial floors are suitable for the Model G0555. Some residential floors may require additional build up to support both the machine and the operator.

- **Working Clearances:** Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your bandsaw.

- **Lighting and Outlets:** Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets or circuits.



⚠CAUTION

Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting, or operating equipment.

Assembling Stand

⚠CAUTION

Some metal parts may have sharp edges that can cause minor injury. Please examine the edges of all metal parts BEFORE handling them and be careful WHILE handling them.

To assemble the stand:

1. Lay one of the stand sides on its back and secure the two lower braces with (4) M6-1.0 x 16 hex bolts, (4) 6mm flat washers, and (4) M6-1.0 flange nuts from the hardware bag.

2. Attach the two upper braces to the stand side in the same manner with (4) M6-1.0 x 16 hex bolts, (4) 6mm flat washers, and (4) M6-1.0 flange nuts from the hardware bag. Your assembly should now look like **Figure 7**.

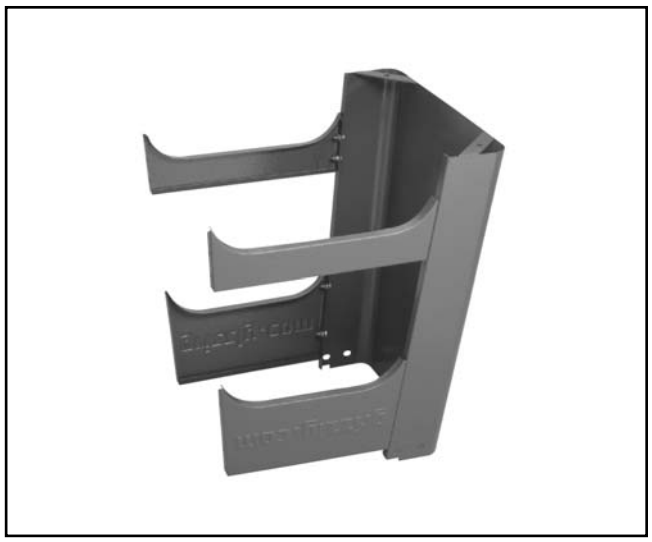


Figure 7. Braces attached to stand side.

3. Attach the second stand side to the assembly with (8) M6-0.8 x 16 hex bolts, (8) 6mm flat washers, and (8) M6-0.8 flange nuts from the hardware bag. Your assembly should now look like **Figure 8**.

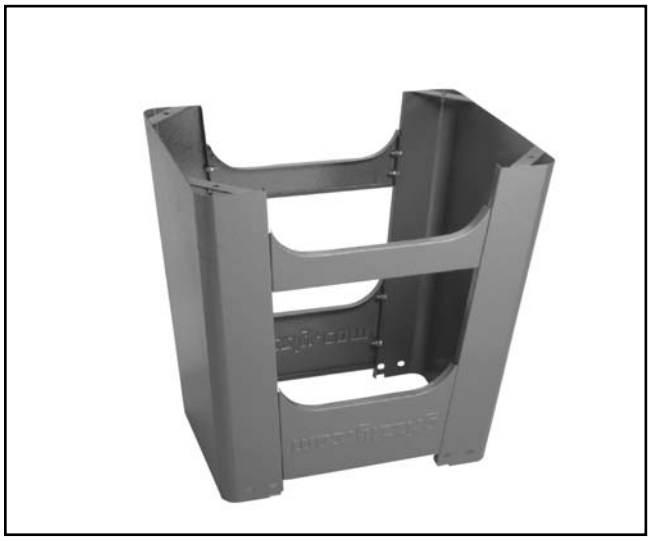


Figure 8. Second stand side attached to assembly.

4. Thread a ⅜"-16 hex nut onto each foot and follow it with a 10mm flat washer.

5. Install the feet into the corner brace of the stand, and secure it with another ⅜"-16 hex nut and 10mm flat washer as shown in **Figure 9**.

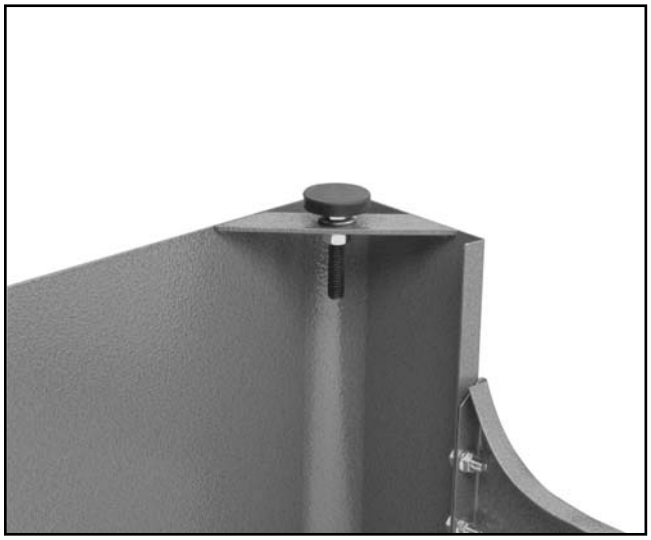


Figure 9. Foot installed into stand corner.

6. Adjust the feet so that they are approximately the same height. *This step will make leveling the stand easier.*

7. Place the 2 top stand braces into the underside of the stand top.

8. Line the braces up with the holes and secure only the end shown in **Figure 10** with (2) M8-1.0 x 16 carriage bolts and (2) M8-1.0 flange nuts from the hardware bag. *The holes in the other end of the brace must be left open to mount the bandsaw unit.*

Figure 10. Installing braces on stand top.

9. Turn the stand assembly upright and secure the stand top to the stand assembly with the remaining (8) M8-1.0 x 16 carriage bolts and (8) M8-1.0 flange nuts from the hardware bag. The stand assembly is now complete and should look similar to **Figure 11**.

Figure 11. Stand top installed on stand assembly.

10. Place a level across the stand top as shown in **Figure 12** and adjust the feet as necessary to make the stand level. Turn the level 90˚ and adjust the stand to be level again. Repeat these two adjustments until the stand is level in both directions.

Figure 12. Leveling stand.

11. Tighten the hex nuts on the feet, so that they are against the underside of the stand and will lock the feet in place to keep the stand level.

Mounting Bandsaw

⚠CAUTION

Get assistance from another person when lifting the bandsaw onto the stand or moderate personal injury may occur.

To mount the bandsaw to the stand:

1. Get an assistant to help you lift the bandsaw and place it on top of the stand.

2. Line up the mounting holes on the bandsaw base with those on the stand top, so that the front of the bandsaw is closer to the stand edge than the back of the bandsaw.

3. Secure the bandsaw to the stand with the (4) M8-1.25 x 35 hex bolts, (8) 8mm flat washers, (4) 8mm lock washers, and (4) M8-1.25 hex nuts from the hardware bag. The bandsaw should now be mounted to the stand as shown in **Figure 13**.

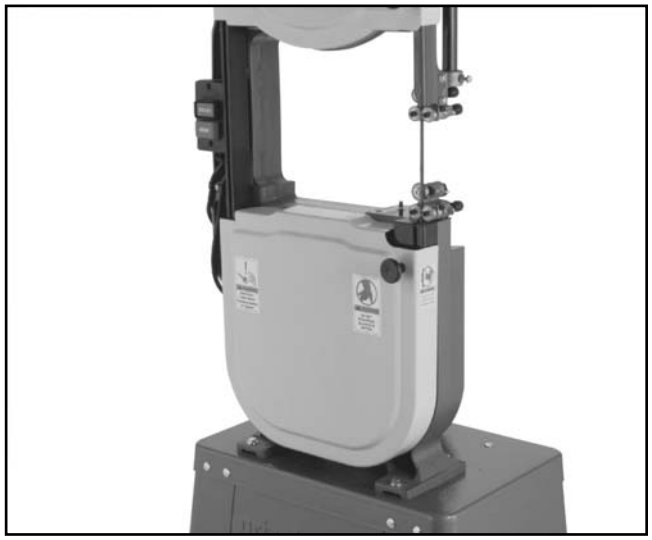


Figure 13. Bandsaw mounted to stand.

Mounting Trunnion Base

To mount the trunnion base:

1. Place the trunnion base on the bandsaw as shown in **Figure 14**.

2. Fasten the trunnion base to the bandsaw with the (2) M8-1.25 x 30 hex bolts and (2) 8mm lock washers from the hardware bag.

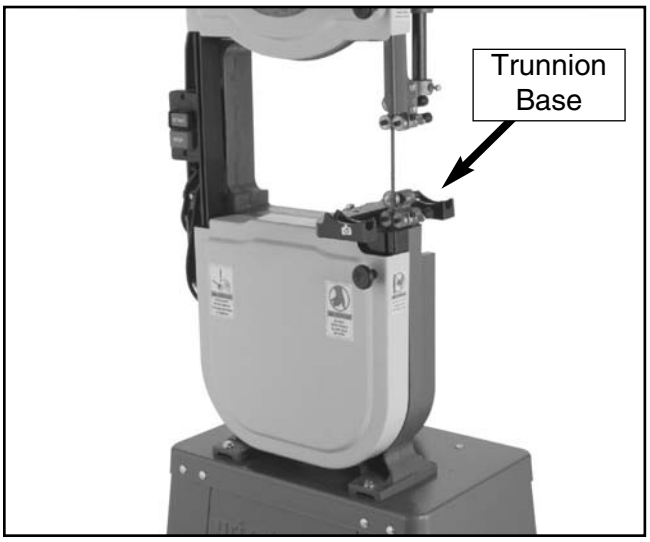


Figure 14. Installing trunnion base.

Installing Positive Stop

To install the positive stop:

1. Locate the M8-1.0 x 80 hex bolt (this is the positive stop bolt) from the hardware bag and thread on the remaining M8-1.0 hex nut from the hardware bag.

2. Thread the positive stop bolt into the bandsaw into the trunnion base so that it is installed similar to **Figure 15**. *The positive stop depth will be set after the table has been installed.*

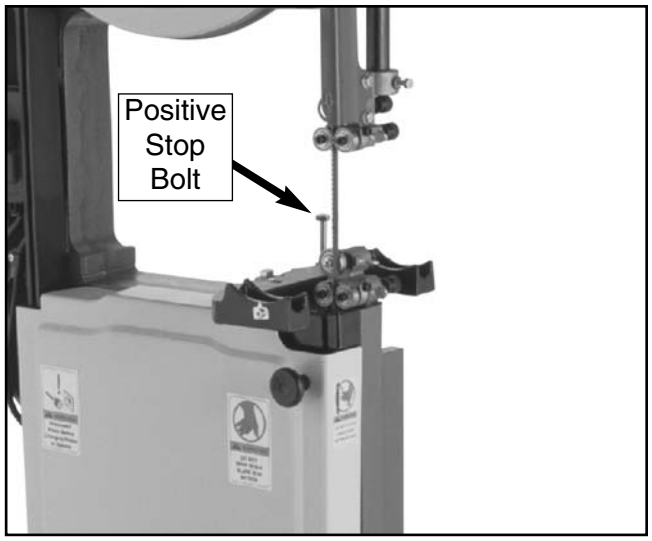


Figure 15. Shows positive stop bolt installed.

Installing Table

To install the table on the bandsaw:

1. Remove the aluminum table insert from the center of the table and remove the table pin from the end of the table slot.

2. Line up the blade with the table slot and pass the table around the blade until the blade is in the center of the table, then turn the table 90˚ counterclockwise and rest the table trunnions on the trunnion base. *The trunnion bolts should be hanging out of the bottom of the trunnion base at this point.*

3. Locate the two knobs from the hardware bag and thread them onto the trunnion bolts that hang out through the bottom of the trunnion base as illustrated in **Figure 16**.

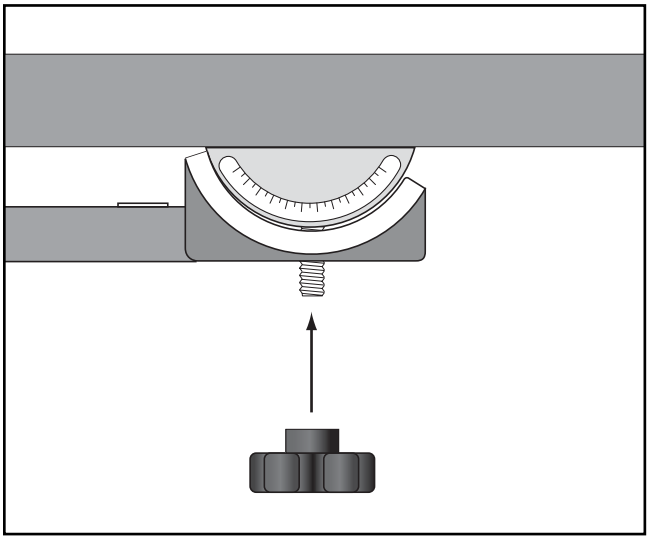


Figure 16. Secure table to trunnion with knobs from hardware bag.

4. Place the table insert in the center of the table, so that it sits flush with the table top surface.

5. Insert the pin into the end of the table slot.

Installing Fence

To install the fence:

1. Fasten the large rail to the front of the bandsaw table with the (2) M6-0.8 x 20 hex bolts, (2) 6mm lock washers, and (2) 6mm flat washers from the hardware bag as shown in **Figure 17**.

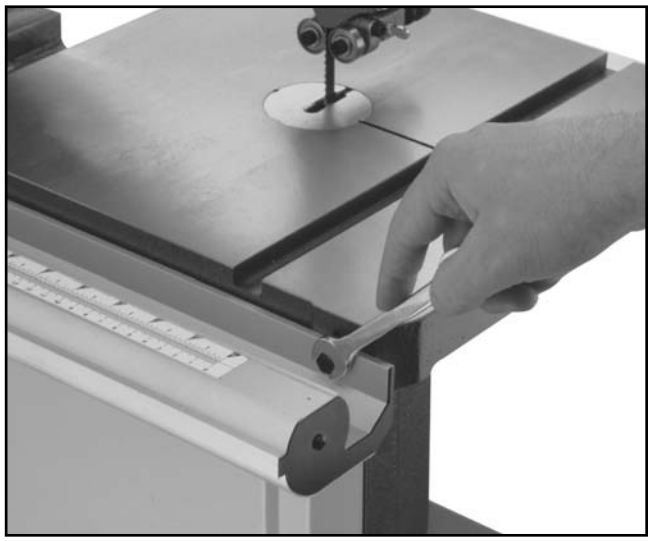


Figure 17. Fastening large rail to table.

2. Fasten the small rail to the back of the bandsaw with the (2) M6-0.8 x 16 cap screws from the hardware bag.

3. Thread the M8-1.0 hex nut from the hardware bag onto the fence handle threads, then thread the fence handle into the fence.

4. Tighten the hex nut (already on the fence handle threads) down to the fence body to keep the fence handle from rotating.

5. Pull the fence handle up and place the fence on the large rail as shown in **Figure 18**.

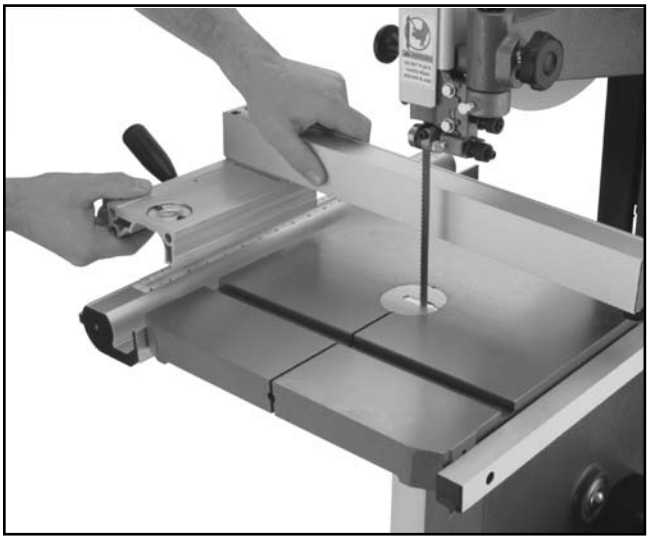


Figure 18. Installing fence onto rails.

6. Push the fence handle down to lock the fence in position.

Connecting Dust Hose

⚠CAUTION

DO NOT operate the Model G0555 without an adequate dust collection system. This machine creates substantial amounts of wood dust while in operation. Failure to use a dust collection system can result in short and long-term respiratory illness.

To connect a dust collection hose:

1. Place a hose clamp over the end of a 4" flexible hose.
2. Fit the 4" flexible hose over the dust port as shown in **Figure 18**.
3. Tighten the hose clamp.
4. Lightly tug the hose to make sure that it does not come off. *A tight fit is necessary for best performance!*

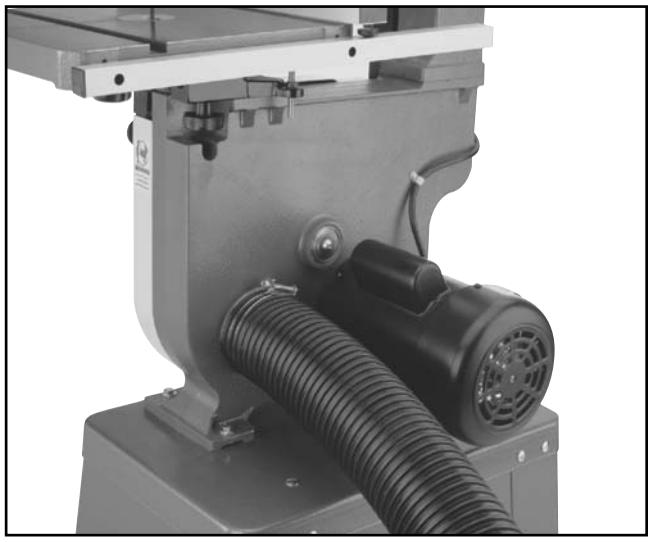


Figure 18. Dust hose attached to dust port.

Blade Tracking

The blade tracking is primarily affected by the tilt of the upper wheel, also known as Center Tracking; and the alignment of both wheels, also known as Coplanar Tracking. (For Coplanar Tracking, see the “Wheel Alignment” instructions in *Section 6: Service Adjustments*.)

The wheels on the Model G0555 were aligned at the factory, so Center Tracking is the only adjustment that needs to be performed when the saw is new.

To center track the blade:

1. **Unplug the bandsaw!**
2. Adjust the upper and lower guide bearings and support bearings away from the blade.
3. Open the upper wheel cover.
4. Adjust blade tension to match the size of the installed blade with the mark on the blade tension scale.

⚠CAUTION

The aluminum spokes may have sharp edges and the blade teeth may extend beyond the edge of the wheel, creating a laceration hazard. Be careful when turning the wheels by hand.

5. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 19** for an illustration of this concept.

   —**If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown**, then the bandsaw is already tracked properly and no further adjustments are needed at this time.

   —**If the blade does not ride in the center of the upper wheel and is not centered on the peak of the wheel crown,** then continue with the following steps.

6. Loosen the lock nut on the tracking control knob threads so that the tracking control knob will rotate for adjustments.

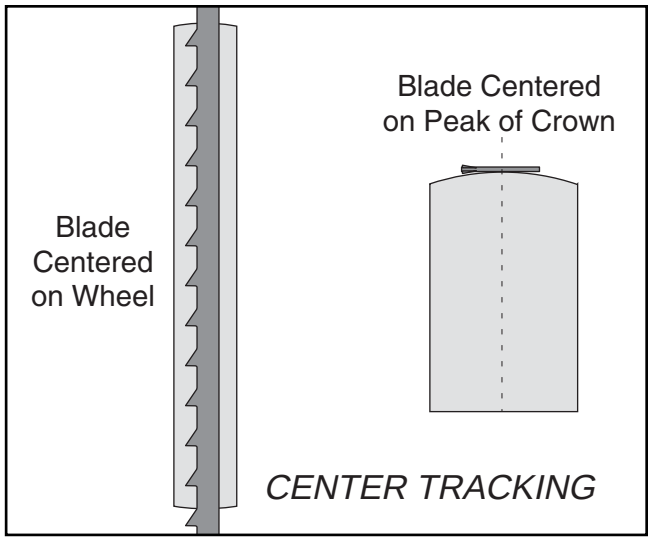


Figure 19. Center tracking profiles.

7. Spin the upper wheel with one hand and rotate the tracking control knob with the other hand to make the blade ride in the center of the bandsaw wheel tire.

8. Tighten the tracking control lock nut and close the upper wheel cover.

For the best performance from your saw, regularly maintain the proper tracking of the blade.

NOTICE

Changes in the blade tension may change the blade tracking.

Test Run

Once the assembly is complete and you have performed the "Blade Tracking" instructions, you need to test run the machine to continue with the remainder of the adjustments.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, feel free to contact our service department for help.

⚠WARNING

Wear safety glasses during the entire test run process. Failure to comply may result in serious personal injury.

To test run the machine:

1. Make sure that you have performed the "Blade Tracking" instructions before continuing with these instructions.

2. Make sure that the blade guides are moved away from the blade and that the blade is not touching the table or table insert.

3. Plug the machine into the power source.

4. Press the *ON* button. *Make sure that your hand stays poised over the switch in case you need to quickly turn the machine OFF.*

5. Listen to and watch the bandsaw for abnormal noises or actions. The bandsaw should run smoothly with little or no vibration or rubbing noises. *Strange or unnatural noises should be investigated and corrected before operating the machine further—always unplug the machine when investigating or correcting any situation with the machine.*

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is a prerequisite before making many bandsaw adjustments.

To tension the bandsaw blade:

1. Make sure you have performed the "Test Run" instructions on the previous page and that the blade is tracking properly.

2. With the blade tension lever in the down (engaged) position, adjust the blade tension so that the mark on the blade tension scale matches the size of blade that is installed on the bandsaw. *Because each blade is different and all blades stretch, this scale can only be considered as a general guide.*

3. Turn the bandsaw *ON*.

4. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.

5. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension one more quarter of a turn.

6. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future. *However, do not rely on this measurement for long periods of time because the blade will stretch with use.*

NOTICE

All bandsaw blades will stretch. To reduce this stretching, remove the tension from the blade when not in use.

NOTICE

After blade tension and tracking are set correctly, properly adjust the upper and lower support bearings and guide-block assemblies into position before cutting operations.

Adjusting Support Bearings

The support bearings are positioned behind the blade and support the back of the blade during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. **Unplug the bandsaw!**

3. Familiarize yourself with the support bearing controls shown in **Figure 20**.

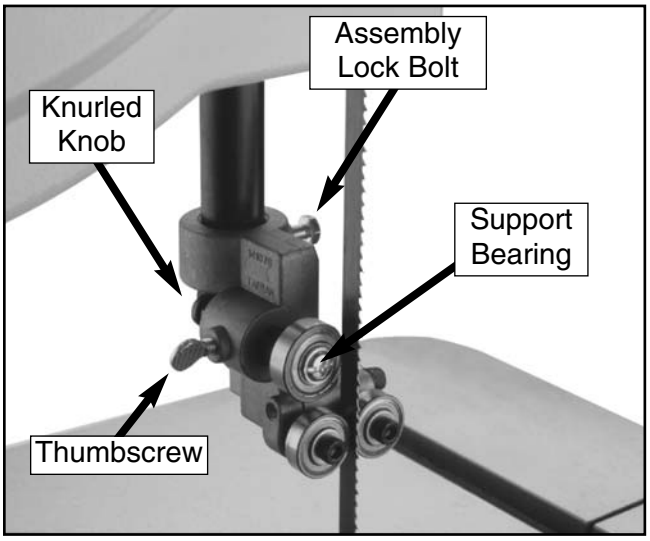


Figure 20. Support bearing controls.

4. Loosen the assembly lock bolt.

5. Look at the face of the support bearing and rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing as illustrated in **Figure 21**.

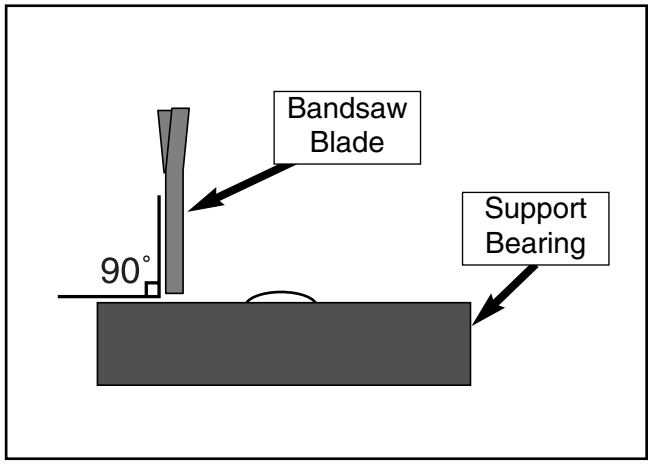


Figure 21. Blade should be perpendicular (90˚) to the face of the support bearing.

6. Tighten the assembly lock bolt.

7. Loosen the thumbscrew on the support bearing adjustment shaft.

8. Use the knurled knob to position the support bearing approximately .016" away from the back of the blade as illustrated in **Figure 22**.

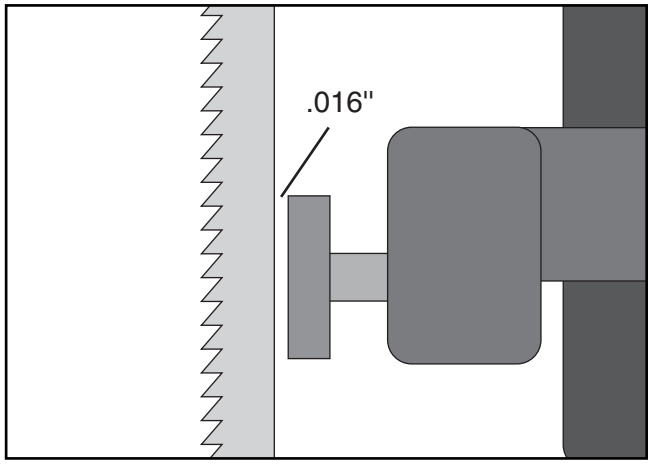


Figure 22. Blade should be aligned approximately .016" away from the bearing edge.

9. For a quick gauge, fold a dollar bill in half twice (four thicknesses of a dollar bill is approximately .016") and place it between the support bearing and the blade as shown in **Figure 23**.

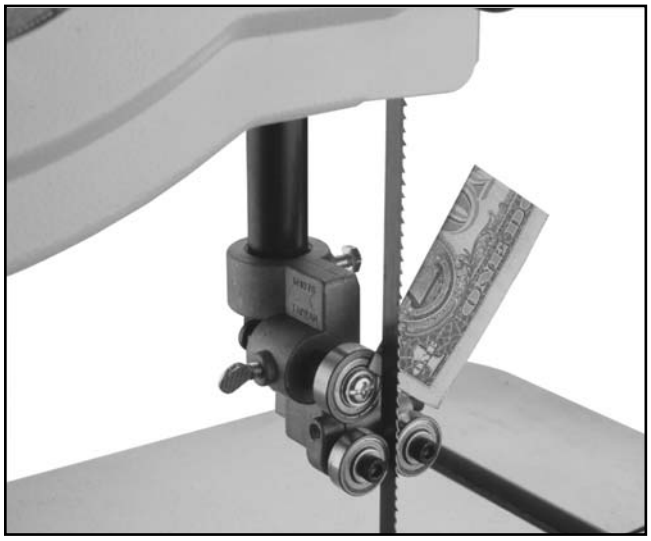


Figure 23. Dollar bill folded twice to make a quick .016" gauge.

10. Tighten the thumbscrew to keep the support bearing locked in place.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide-blocks must be properly adjusted before cutting operations.

Adjusting Blade Guides

The blade guides provide side-to-side support to help keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side. Properly adjusted blade guides are essential to making accurate cuts.

To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. **Unplug the bandsaw!**

3. Familiarize yourself with the blade guide controls shown in **Figure 24**.

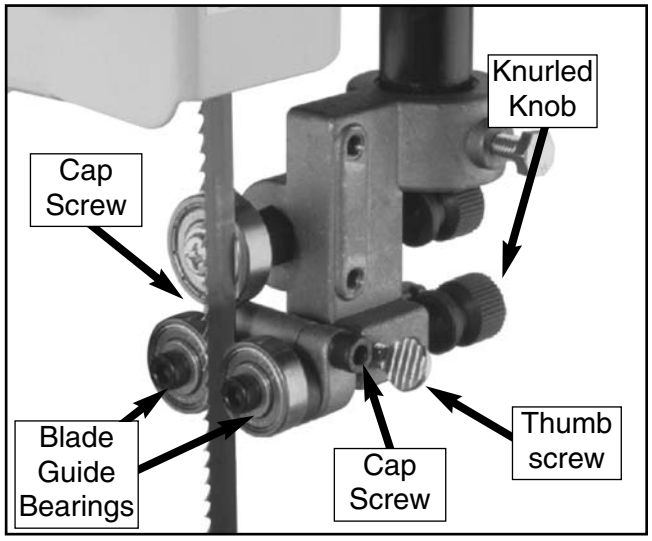


Figure 24. Blade guide controls.

4. Loosen the thumbscrew on the forward/backward adjustment rod.

5. Rotate the knurled knob behind the blade guides to position the blade guides laterally, so that the edges of the bearings are just behind the blade gullets as illustrated in **Figure 25**.

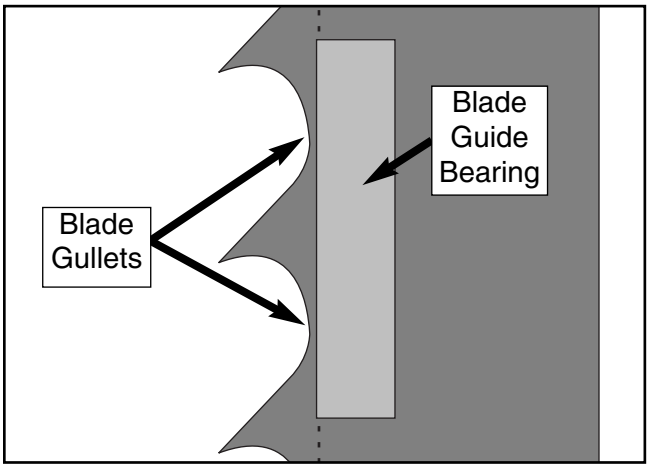


Figure 25. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide bearings when the blade is against the rear support bearing during the cut.

6. Tighten the thumbscrew on the lateral adjustment rod so that the knurled knob will not turn.

7. Use an Allen wrench to loosen the cap screws behind the blade guides.

8. With an Allen wrench, rotate the center portion of the blade guides to position the bearings so they make light contact on both sides of the blade as illustrated in **Figure 26**.

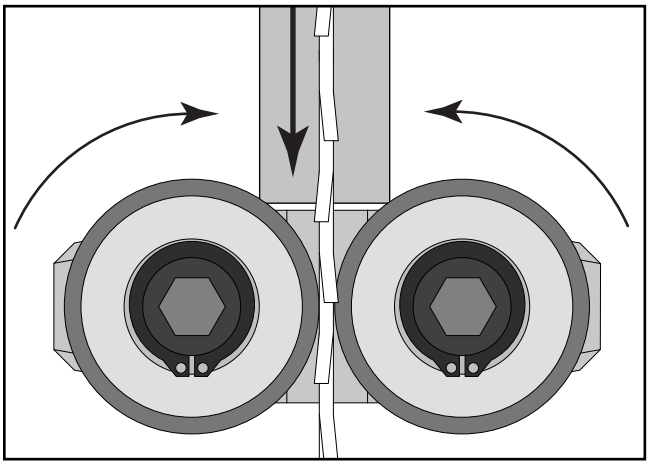


Figure 26. Blade guide bearings against both sides of blade.

NOTICE

The blade guides should NOT have firm pressure against the blade.

9. Tighten the cap screws to lock the blade guides in position. *Note—after the blade guides are locked in place, the bearings should still spin.*

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide-blocks must be properly adjusted before cutting operations.

Adjusting Positive Stop

There is an adjustable positive stop that allows the table to be reset perpendicular (90˚) to the blade after tilting to the right.

To set the positive stop 90˚ to the blade:

1. Make sure the blade is correctly tensioned as described in the "Tensioning Blade" instructions.

2. **Unplug the bandsaw!**

3. Loosen the two plastic knobs that secure the table to the trunnions.

4. Loosen the check-nut that locks the positive stop adjusting bolt in place.

5. Raise the upper blade guide assembly and place a 6" machinist's square or try-square on the table next to the side of the blade as illustrated in **Figure 27**. Adjust the positive stop bolt to raise or lower the table until the table is 90˚ to the blade.

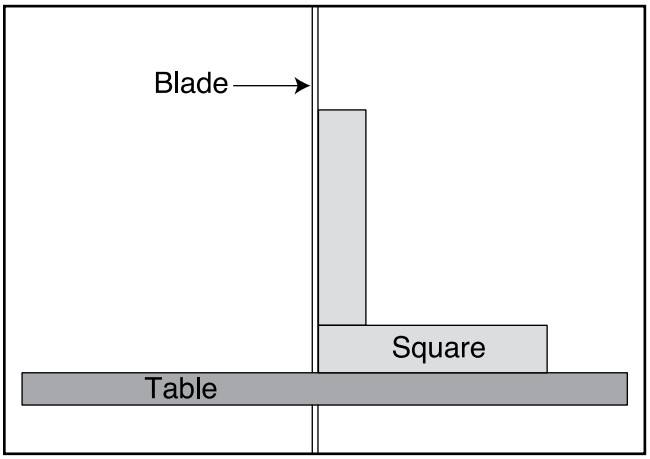


Figure 27. Squaring table to blade.

6. Secure the plastic knobs and lock the positive stop bolt by tightening the check-nut. *Ensure that the bolt does not turn while tightening the check-nut with another wrench.*

Setting Table Tilt Scale to 0˚

The pointer on the table tilt scale must be calibrated in order for the scale reading to be accurate.

To calibrate the pointer on the table tilt scale:

1. Make sure that the blade is tensioned and is tracking correctly, and that the table is 90˚ to the blade (this procedure should be already completed with the "Adjusting Positive Stop" instructions).

2. Loosen the screw on the pointer so that the pointer is able to move.

3. Align the tip of the pointer with the 0˚ mark on the table tilt scale.

4. Tighten the screw on the pointer so that the pointer is locked in place.

Aligning Table

To ensure cutting accuracy when the table is first installed, the table should be aligned so that the miter slot is parallel to the bandsaw blade. *This procedure works best with a ¾" blade.*

To align the miter slot parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. **Unplug the bandsaw!**

3. Loosen the trunnion bolts that secure the trunnions to the table.

4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.

5. Use a fine ruler to gauge the distance between the blade and the miter slot. The distance you measure should be the same at both the front and the back of the table.

6. Adjust the table in the desired direction.

7. Tighten the trunnion bolts.

Aligning Fence

To ensure cutting accuracy when the fence is first installed, the fence should be aligned with the miter slot.

To align the fence parallel with the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and remount it on the right-hand side of the blade.

2. Loosen the 4 cap screws located on the top face of the fence.

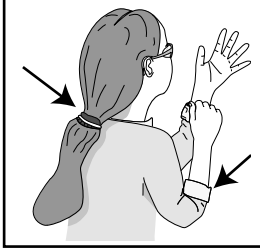
3. Adjust the fence face parallel with the edge of the miter slot.

4. Tighten the 4 cap screws, being careful not to move the fence.

NOTICE

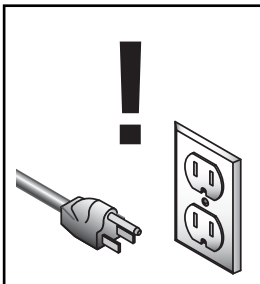
Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the "Aligning Table" section.

SECTION 6: OPERATIONS



⚠WARNING

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.

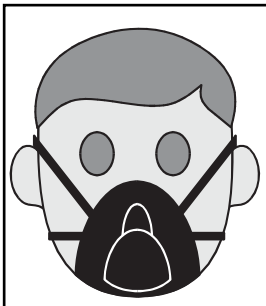


⚠WARNING

Disconnect power to the machine when performing any maintenance or assembly. Failure to do this may result in serious personal injury.

⚠WARNING

Wear safety glasses during the entire operation process. Failure to comply may result in serious personal injury.



⚠CAUTION

Using this machine produces sawdust which may cause allergic reactions and respiratory problems. Use an approved dust mask to protect yourself from these hazards!

NOTICE

The following section was designed to give instructions on the basic operations of this bandsaw. However, it is in no way comprehensive of every bandsaw application. There are many different jigs that can be built to increase safety, accuracy, and types of cuts. WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your machine.

Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing many different cutting functions including, but not limited to:

STRAIGHT CUTS

- **Miters**
- **Angles**
- **Compound Angles**
- **Resawing**
- **Ripping**
- **Crosscutting**

IRREGULAR CUTS

- **Simple and Complex Curves**
- **Duplicate Parts**
- **Circles**
- **Beveled Curves**

Although you can perform many types of straight cuts such as angling and mitering on the bandsaw, they will not be as precise as on a table saw. Also, since the blade is flexible, the resulting cut is somewhat rougher than one performed on a table saw. However, just as a table saw is suited to precision straight cuts and miters, the bandsaw excels when resawing and when cutting irregular shapes.

A properly adjusted and tuned up bandsaw can be safer to operate than most other saws and is capable of performing many sawing functions with ease and accuracy.

A common fault when using a bandsaw is blaming the saw for not performing up to expectations. Many factors contribute to the performance of a bandsaw. Using the wrong kind of blade for the job or using a poor quality blade will result in unsatisfactory performance. Other performance issues can usually be linked to improper set up or overlooked adjustment procedures.

Here are some basic tips to follow when operating the bandsaw:

- Replace and clean blades as necessary and make adjustments periodically to keep the saw always running in top condition.
- Use light and even pressure while cutting. Light contact with the blade will permit easier line following and prevent undue friction and heat.
- Avoid trying to turn sharp corners because this will twist the blade. Remember, you must SAW around corners.
- Misuse of the saw or using incorrect sawing techniques can be unsafe as well as result in frustration and poor cuts. Remember—the blade does the cutting with the operator's guidance.

Table Tilt

The bandsaw table will tilt 10˚ left and 45˚ right to provide a wide range of cutting options.

To tilt the table:

1. Loosen the two plastic knobs underneath the table that lock the table trunnion.
2. Position the table to the desired angle of tilt. Refer to the angle gauge on the front table trunnion for the tilting angle.
3. Retighten both plastic knobs.

NOTICE

If setting table tilt to the left, it will be necessary to remove the positive stop.

Guide Post

The guide post (shown in **Figure 28**) connects the upper blade guide assembly to the bandsaw. The function of the guidepost is to allow the blade guide assembly to move up or down depending on the height of the workpiece being cut. In order to cut accurately, the blade guide assembly must be no more than 1" from the top of the workpiece at all times—this positioning provides the greatest support to the blade.

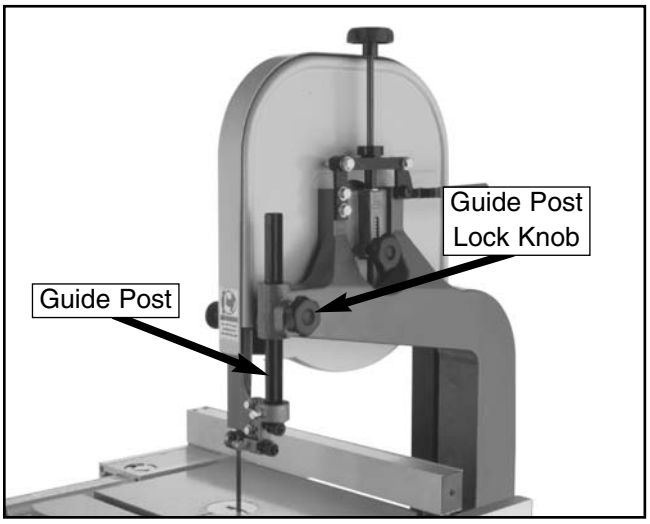


Figure 28. Guide post controls.

To adjust guide post assembly alignment on the guide post:

1. Make sure that the blade tension, blade tracking, support bearing and blade guides are adjusted correctly.
2. Loosen the guide post lock knob shown in **Figure 28**.
3. Raise/lower the guide post so that there is not more than 1" from the top of the workpiece to the bottom of the blade guide assembly.
4. Lock the guide post in place with the lock knob.

Ripping

Ripping is the process of cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece.

⚠CAUTION

DO NOT operate the Model G0555 without an adequate dust collection system. This machine creates substantial amounts of wood dust while in operation. Failure to use a dust collection system can result in short and long-term respiratory illness.

To rip with the Model G0555:

1. Adjust the fence to match the width of the cut on your workpiece and lock the fence in place.

2. Make sure all safety precautions have been taken and start the bandsaw.

⚠WARNING

NEVER place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may be pulled into the blade. ALWAYS use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!

3. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 29** shows a typical ripping operation. *If you are cutting narrow pieces, use a push stick to protect your fingers.*

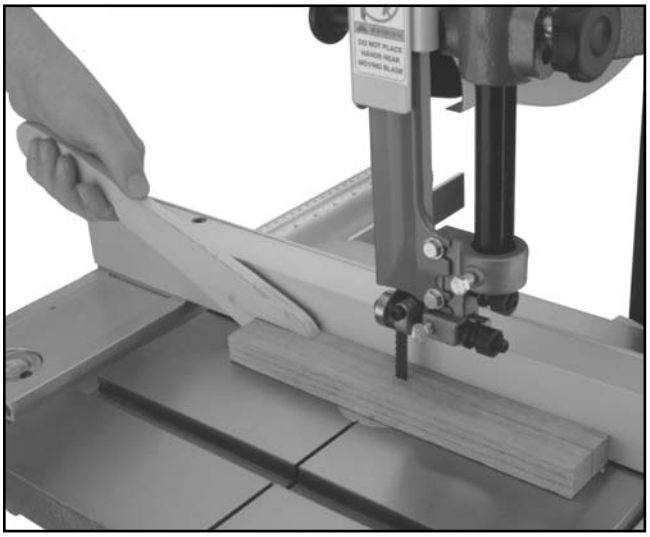


Figure 29. Ripping with a push stick.

Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

To crosscut with the Model G0555:

1. Mark the workpiece on the edge where you want to begin the cut.

2. Move the fence out of the way. Place the workpiece evenly against the miter gauge.

3. Line up the mark with the blade, having the blade kerf poised to cut through the waste portion of the workpiece.

4. After all safety precautions have been met, start the bandsaw. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 30** shows a typical crosscutting operation.

Figure 30. Crosscutting with miter gauge.

Resawing

Resawing (**Figure 31**) is the process of cutting a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw. Maximum cutting height for this bandsaw is 6".

The Model G0555 14" Bandsaw is capable of resawing, provided the saw is set up properly. Use common sense when resawing. Attempting to resaw too wide or too dense of a board may put excessive strain on the blade and cause it to break.

One of the most important considerations when resawing is blade selection. Generally, the wider blade, the better. In most applications, a hook or a skip tooth style will be desirable. Also, since most resawn lumber will be planed smooth, you should choose blades with fewer teeth-per-inch (from 3 to 6). While blades with fewer teeth-per-inch produce rougher cuts, these types of blades offer larger gullet capacities for clearing sawdust.

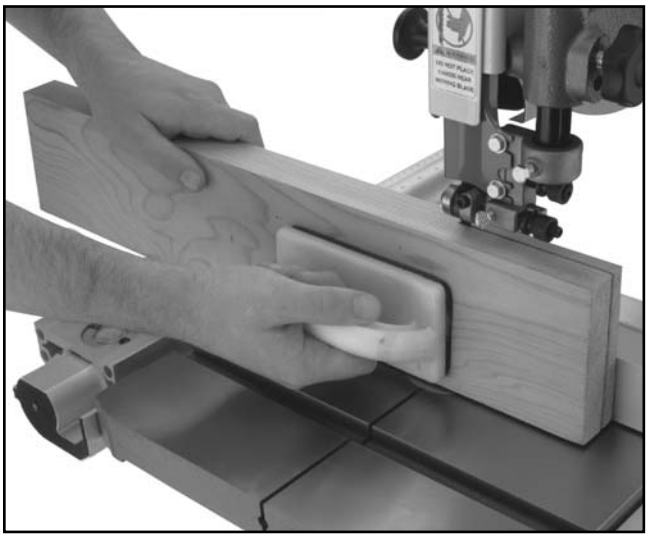


Figure 31. Resawing lumber.

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the table is perpendicular to the blade.

2. Use the widest blade your bandsaw will accept. *The blade must also be sharp and clean.*

3. Use a fence to guide the work.

4. Set your fence to the desired width of cut and lock it in place. Or, draw a reference line on the edge of the board, place the board against the fence, line up the reference line with the blade and lock the fence in place.

5. Support the ends of the board if necessary.

6. Turn the bandsaw *ON*.

7. Keeping pressure against the fence and table, slowly feed the workpiece into the moving blade until the blade is completely through the workpiece.

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without being twisted. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use either a narrower blade or a blade with more T.P.I. (teeth per inch). A blade with more T.P.I. can cut a relatively tighter radius, though the cut is usually rougher than cuts produced by a blade with a medium amount of T.P.I.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. ***RELIEF CUTS are cuts made through the waste portion of the workpiece and are stopped at the layout line.*** As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii each size of blade for the Model G0555.

Width	Radius
⅛"	⅛"
3/16"	⅜"
¼"	⅝"
⅜"	1¼"
½"	2½"
⅝"	3¾"
¾"	5½"

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90°. Otherwise, any error will be compounded with each piece cut from the top to the bottom of the stack.

To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.

2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as does brad nails through the waste portion. (Be careful not to cut into the brads!)

3. On the face of the top piece, lay out the shape you intend to cut.

4. Make relief cuts (see definition on **page 29**) perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade kerf to bind.

5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line as shown in **Figure 32**.

⚠CAUTION

Cutting into brad nails that are used to secure the multiple pieces can cause the blade to break and may cause an injury to the operator. Be extremely careful of where you are cutting when performing this operation.

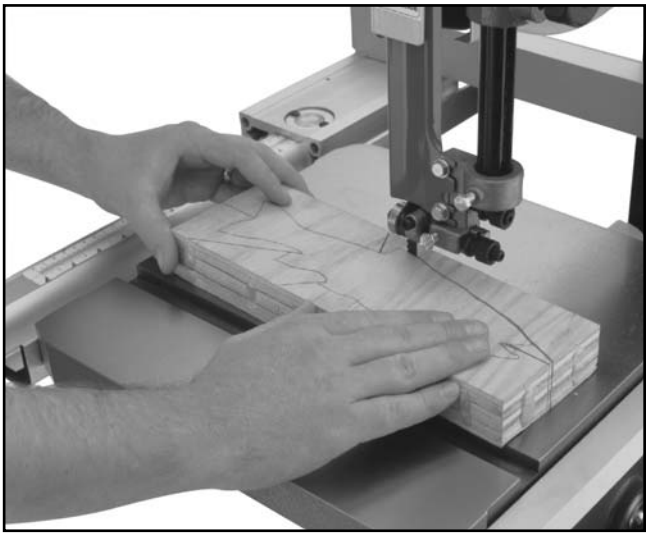


Figure 32. Cutting multiple pieces at once.

Blade Speed

The Model G0555 offers blade speeds of 1500 & 3200 FPM. For general woodworking and most cutting operations, we recommend using the 3200 FPM speed. Keep in mind, the results from different speeds are related to the type of blade being used—whenever determining SPEED, also choose a type of blade that is related to your operation. **Use the chart below as a general guide to blade speed:**

Type of Cutting Operation	Blade Speed
Most Species of Wood	3200 FPM
Super Dense Hardwood	1500 FPM
Fast/Average Feed Rate	3200 FPM
Requires Slow Feed Rate	1500 FPM
Rough Edges Tolerable	3200 FPM
Requires Smooth Edges	1500 FPM
Quick, Production Cuts	3200 FPM
Detailed, Intricate Cuts	1500 FPM

Speed changes are performed by moving the V-belt to one of the two sets of pulleys.

To change the blade speed:

1. **Unplug the bandsaw!**

2. Open the lower wheel cover.

3. Loosen the motor mount bolts shown in **Figure 33**.

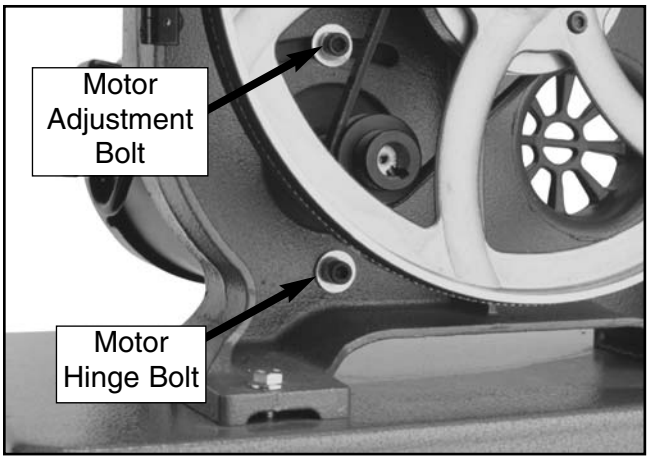


Figure 33. Motor mount bolts.

4. Move the body of the motor so that the motor adjustment bolt slides to the right-hand side (facing bandsaw front) of the adjustment slot.

5. Place the V-belt in the wheel pulley and motor pulley grooves as illustrated in **Figure 34** for your desired speed.

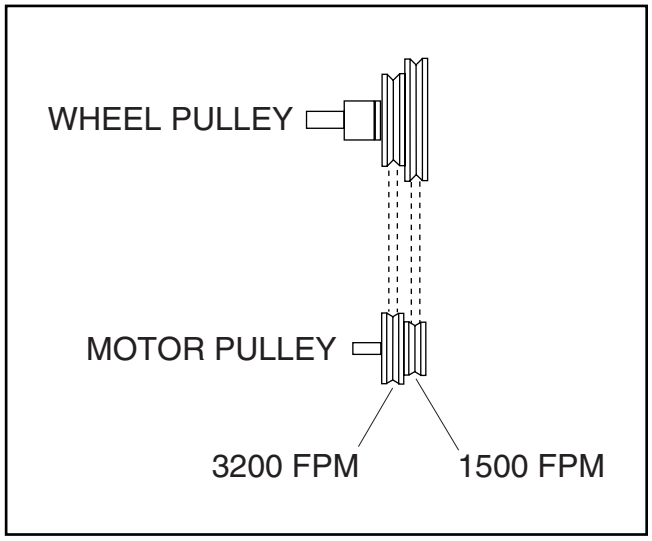


Figure 34. Bandsaw speed diagram.

6. Move the body of the motor so that the motor hinge bolt slides to the left-hand side (facing bandsaw front) of the adjustment slot.

7. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.

8. Push the center of the V-belt. If deflection is approximately ¾" with moderate pressure from your thumb or finger, then the tension is correct. If the deflection is more than ¾", repeat **steps 3-6**.

9. When the V-belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Blade Information

Selecting the right blade requires a combination of the various blade characteristics mentioned below, the type of material you plan to cut, and the type of cut you are going to perform.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0555 is designed for blades that are 92½" long. Refer to the current Grizzly catalog for prices and ordering information.

Blade Width

Measured from the the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

The Model G0555 can use blades from ⅛" to ¾" in width. Always pick the size of blade that best suits your application.

- **Curve Cutting** — Use the chart in **Figure 35** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding width blade.

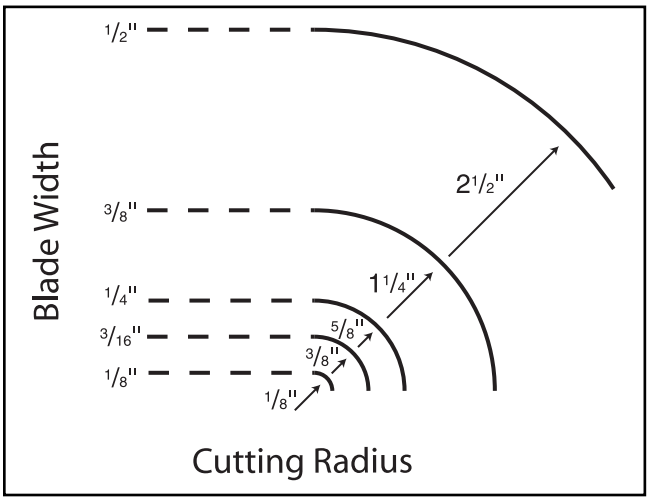


Figure 35. Blade width radii for most common curve cutting blades.

- **Straight Cutting** — Use the largest width blade that you own. The Model G0555 will accept blades up to ¾" wide. Narrow blades can cut tight curves (a small radius) but are not very good at cutting straight lines because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines, but function poorly at cutting small curves because of their size.

Tooth Style

When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle — otherwise known as "Tooth Style."

Figure 36 shows the three main categories of tooth style:

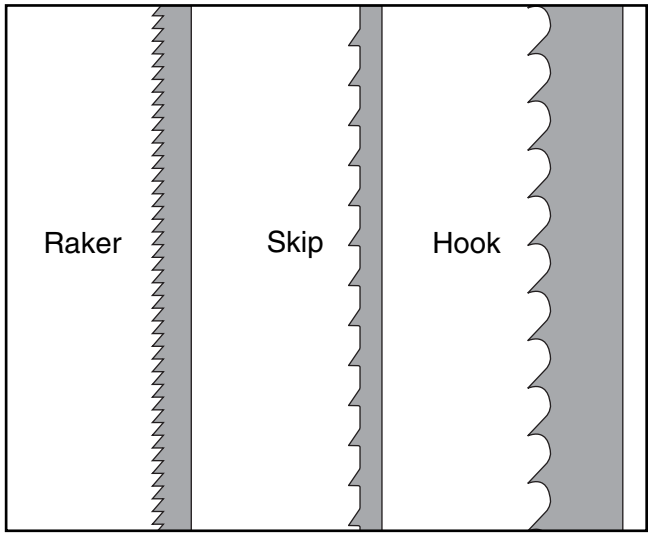


Figure 36. Raker, Skip & Hook tooth styles.

- RAKER — This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on Raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but at the same time do not cut fast and generate more heat while cutting.

- SKIP — This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.

- HOOK — The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Usually measured as T.P.I. (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

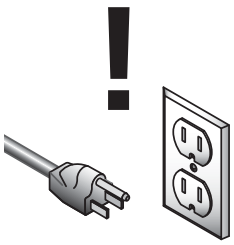
A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are: (1) faulty alignment and adjustment of the guides, (2) forcing or twisting a wide blade around a curve of short radius, (3) feeding the workpiece into the blade too fast, (4) tooth dullness or absence of sufficient set, (5) excessive tension, (6) top blade guide assembly set too high above the work piece, (7) using a blade with a lumpy or improperly finished braze or weld and (8) continuously running the bandsaw when not in use.

Blade Changes



⚠WARNING

Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.

To remove the blade:

1. **Unplug the bandsaw!**

2. Release tension on the blade by turning the tension control knob counter-clockwise.

3. Remove the table insert and the table pin. Adjust the upper and lower guide blocks away from the blade.

⚠CAUTION

Wear gloves and safety goggles when handling blades. Coiled blades spring open as they are uncoiled and could cause deep punctures or lacerations.

4. Open the upper and lower wheel covers and slide the blade off both wheels. Use caution — the blades are sharp!

5. Rotate the blade 90˚ so it will slide through the slot in the table.

To replace the blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table. *If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it rightside-out.*

2. Slip the blade through the upper and lower guides, and mount it over the upper and lower wheels.

3. Apply tension, then check and adjust tracking.

4. Adjust the upper and lower guide blocks and the support bearings.

5. Close and tighten the wheel covers.

6. Replace the table insert and table pin, being sure not to use excessive force when inserting the table pin.

Scale Calibration

You may need to recalibrate the fence scale after changing or adjusting the blade, or if the scale is not producing accurate cuts. Recalibrate the fence scale by adjusting the hairline indicator on the fence and testing your adjustment by cutting a piece of scrap wood.

To calibrate the scale:

1. Set the fence anywhere along the scale and locate a scrap piece of wood with at least one straight edge. *Joint the edge with a jointer if needed to make a straight edge.*

2. Holding the straight edge of the workpiece firmly against the fence, feed the workpiece through the saw blade with a push stick.

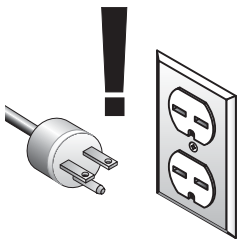
3. Measure the width of the cut workpiece. The width of the workpiece should be the same as the reading on the fence scale.

4. If the reading on the scale is not the same as the width of the cut workpiece, loosen the screws on the magnifying window as shown in **Figure 37** and adjust it to match the width of the cut workpiece.

5. Tighten the screws and the scale is now correctly calibrated.

Figure 37. Scale recalibration screws.

SECTION 7: MAINTENANCE



⚠WARNING

Always disconnect power to the machine when performing maintenance. Failure to do this may result in serious personal injury.

General Maintenance

As a general rule, always keep your bandsaw clean and free of any built-up dust. Regularly use compressed air or a dry rag to remove sawdust from the inside and outside of the bandsaw. *Remember to wear safety glasses and a dust mask when cleaning off sawdust—especially if you are using compressed air!*

Miscellaneous

Always be aware of the condition of your bandsaw. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts
- Worn switch
- Worn or damaged blade
- Worn or damaged support bearings or guide bearings
- Loose V-belt tension, or cracked/glazed appearance.
- Cracked or deteriorating polyurethane tires.

Table

The table and other non-painted surfaces on the Model G0555 should be protected against rust and pitting. Wiping the saw clean after every use ensures that wood dust is not allowed to trap moisture against bare metal surfaces.

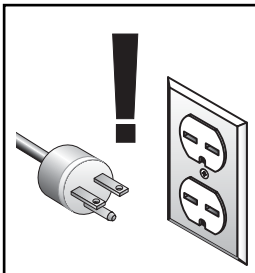
The table can be kept rust-free with regular applications of products like SLIPIT® or Boeshield® T-9. For long term storage you may want to consider products like Kleen Bore's Rust Guardit™. See the current Grizzly catalog for more on these products.

Lubrication

Sealed and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or bearing supply store.

As for other items on this machine, such as adjustment controls, an occasional “shot” of light oil is just about all that is necessary. Before applying, however, wipe off any sawdust with a clean cloth, towel or dry paint brush, and spray on the lubricant. Ensure that oil does not get on the pulleys or V-belt because it could cause belt deterioration and slipping.

SECTION 8: SERVICE ADJUSTMENTS



⚠WARNING

Always disconnect power to the machine when making adjustments. Failure to do this may result in serious personal injury.

About Service

This section is designed to help the operator with adjustments that were made at the factory and might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustment needs to be made that is not described in this manual, then feel free to call the Grizzly Service Department.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

Checking V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension. The belts should be checked for cracks, fraying, and wear. Belt tension should be checked at least every 3 months — more often if the bandsaw is used daily.

The check the V-belt:

1. **Unplug the bandsaw!**
2. Open the lower wheel cover.
3. Push the center of the V-belt. Note the amount of deflection. If deflection is more than approximately ¾" with moderate pressure from your thumb or finger, tighten the V-belt.
4. Note the condition of the V-belt. If the V-belt is cracked, frayed, or glazed; it should be replaced as soon as convenient.

Tensioning V-Belt

To tension the V-belt:

1. **Unplug the bandsaw!**
2. Open the lower wheel cover.
3. Loosen the motor mount bolts shown in **Figure 38**.

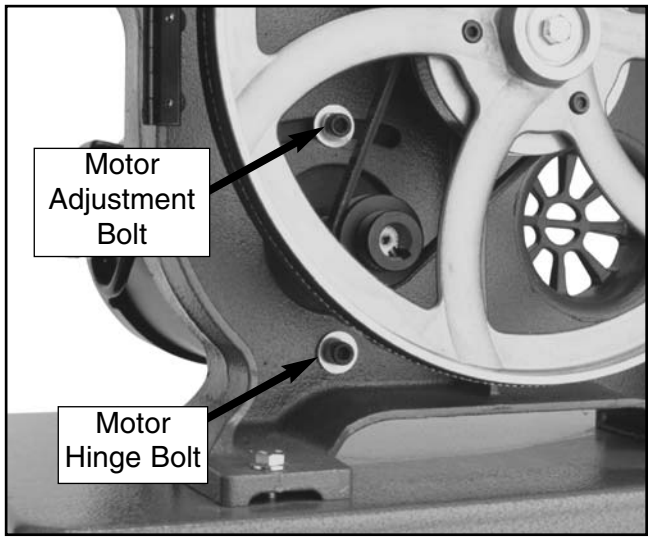


Figure 38. Motor mount bolts.

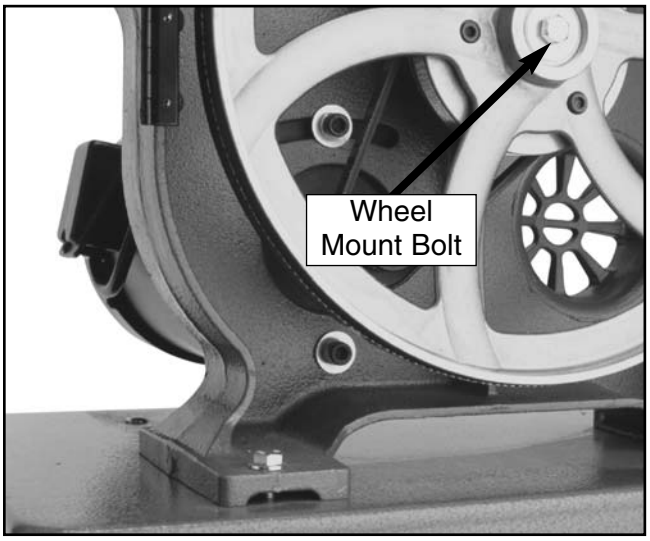


Figure 39. Wheel mount bolt.

4. Move the body of the motor so that the motor adjustment bolt slides to the left-hand side (facing bandsaw front) of the adjustment slot.

5. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.

6. Push the center of the V-belt. If deflection is approximately ¾" with moderate pressure from your thumb or finger, then the tension is correct. If the deflection is more than ¾", repeat **steps 3-6**.

7. When the V-belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Replacing V-Belt

To replace the V-belt:

1. **Unplug the bandsaw!**

2. Open both wheel covers.

3. Remove the bandsaw blade.

4. Loosen the motor mount bolts shown in **Figure 38**.

5. Move the body of the motor so that the motor adjustment bolt slides to the right-hand side (facing bandsaw front) of the adjustment slot and pull the V-belt off of the motor pulley.

6. Unthread the wheel mount bolt shown in **Figure 39** and slide the lower wheel off of the bearing shaft.

7. Slip the old V-belt off of the wheel pulley and install the new V-belt in its place.

8. Install the lower wheel back onto the bearing shaft and replace/tighten the wheel mount bolt.

9. Position the V-belt over the motor pulley. Move the body of the motor so that the motor adjustment bolt slides to the left-hand side (facing bandsaw front) of the adjustment slot.

10. Hold the motor in position with one hand and tighten the motor adjustment bolt with the other hand.

11. Check the V-belt tension and adjust if necessary as described in “Tensioning V-Belt” instructions.

12. When the V-belt tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Shimming Table

To ensure accuracy when cutting stacked cuts or circles, the table should also be 90˚ to the back of the blade as shown in **Figure 40**. If you should find that the table is not perpendicular to the back of the blade, the table will need to be shimmed.

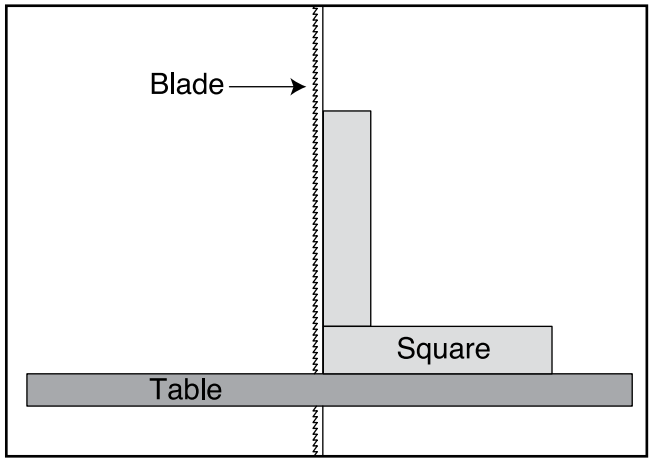


Figure 40. Squaring table to blade back.

To shim the table:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. **Unplug the bandsaw!**

3. Loosen the trunnion bolts that secure the trunnions to the table.

4. Place shim stock between the table and the two trunnions to shim the table in the desired direction. *Another way to shim the table is to add washers between the table and the trunnion. Electrical washers are a good choice for this procedure because they are very thin and will allow for fine adjustment.*

5. Follow the "Aligning Miter Slot" instructions in *Section 4: Set Up* to complete this procedure.

Blade Lead

Most bandsaw blades will not appear to cut straight when using the fence or miter gauge. This is called "lead." (See **Figure 41.**) Lead occurs (1) if the blade tension is incorrect, (2) if the teeth are dull on one side, or (3) if the teeth are set heavier on one side of the blade than the other.

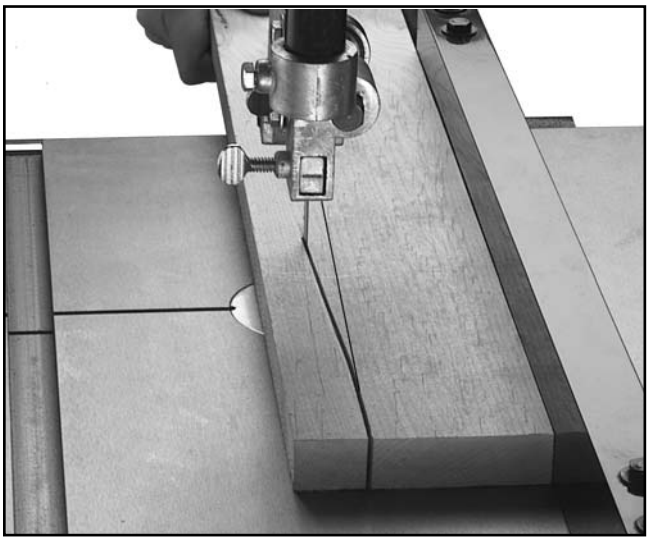


Figure 41. Blade leading away from line of cut.

If you notice that your blade is not cutting straight (i.e. leading) while using the fence or miter gauge:

1. Check that the miter slot or fence is parallel to the blade line.

2. Check that you have proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by skewing the fence or adjusting the table.

To skew your fence:

1. Cut a piece of scrap wood approximately ¾" thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.

2. Slide the fence out of the way and cut freehand along the line. Stop at the halfway point. Turn the bandsaw off and *wait for the blade to stop.*

3. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.

4. Loosen the four skewing cap screws on top of the fence.

5. Skew the fence left or right so it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.

6. While maintaining the skew, tighten the cap screws.

To compensate for lead if making straight crosscuts using the miter gauge, you will need to shift the table. To do this:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge. Starting where the line begins, cut the board by pushing it through the blade with the miter gauge. *The miter gauge should be checked for square before beginning this procedure.*

2. Loosen the table mounting bolts according to the instructions about "Table Adjustments" on **page 20**. Shift the table to compensate for the blade lead.

3. Repeat **steps 1 & 2** until the blade cuts straight when wood is pushed through with the miter gauge.

NOTICE

If the table is shifted, the fence will be affected since it is attached.

NOTICE

Lead adjustments will change when new blades are mounted on the saw.

Wheel Alignment

Wheel alignment is one of the easiest ways to ensure you get optimal performance from your bandsaw. When wheels are aligned, or coplanar, the bandsaw is more likely to cut straight without wandering; and vibration, heat, and blade wear are considerably decreased because the blade is automatically balanced on the wheel. This is known as **"Coplanar Tracking."**

To verify if the the upper and lower wheels are coplanar:

1. With the blade on and properly tensioned, hold a straightedge close to the center of both wheels. Make sure the straightedge fully extends across the wheels as shown in **Figure 42**.

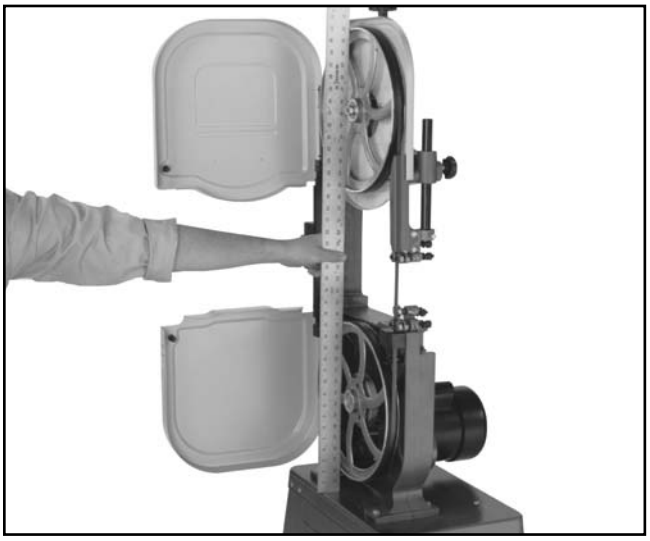


Figure 42. Checking wheel alignment with a straightedge.

2. A perfectly coplanar set of wheels will allow the straightedge to touch the top and bottom of the outside rims on each wheel. If this is the case with your wheels, then they are coplanar.

3. If your wheels are not coplanar, check them for adjustment by placing the straightedge on the lower wheel first – ensuring that it touches both the top and bottom rim – and adjust the tracking knob to see how the straightedge lines up with the upper wheel.

If the straightedge will not touch the top and bottom rim of the upper wheel evenly, first determine if the upper wheel needs to be moved forward or backward. You can only shim the wheels to come forward.

- If the forwardmost wheel is behind the straightedge, then the forwardmost wheel can be shimmed.

- If the forwardmost wheel comes forward from the plane of the lower wheel, the lower wheel needs to be shimmed forward, so the straightedge lines up even with both wheels.

Shimming a wheel:

1. Adjust the tracking knob so that the top wheel is parallel with the bottom wheel. With the straightedge touching both points of the wheel that does not need to be adjusted, measure the distance away from the incorrect wheel with a fine ruler. See **Figure 43**. The distance you measured with the ruler is the distance the wheel must be corrected.

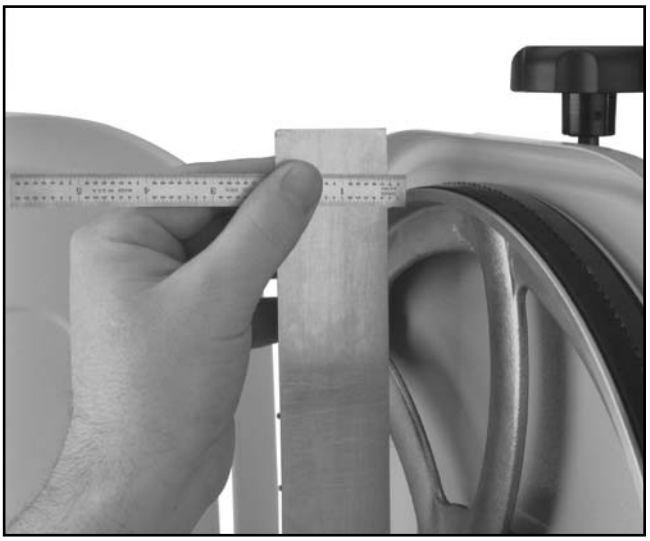


Figure 43. Measuring wheel difference.

2. Remove the blade from the saw, then remove the securing nut and the washers from the wheel that needs to be shimmed. Take the wheel off.

3. Electrical washers work well for shimming because they are offered in a wide range of thicknesses. Measure how many you will need and place them on the mounting shaft.

4. Replace the wheel, any remaining washers, and the securing nut. Tighten the blade as it will be used during operation before you check the wheels. Often the wheels may be coplanar with the blade loose, then be pulled out of alignment when it is tightened.

5. The first time you get the wheels coplanar, place a mark on each wheel where you held the straightedge. This assures repeated accuracy every time you adjust your wheels.

When wheels are properly coplanar, the blade may not be centered on the crown of the wheel, but it will be balanced. See **Figure 44** to better understand coplanarity.

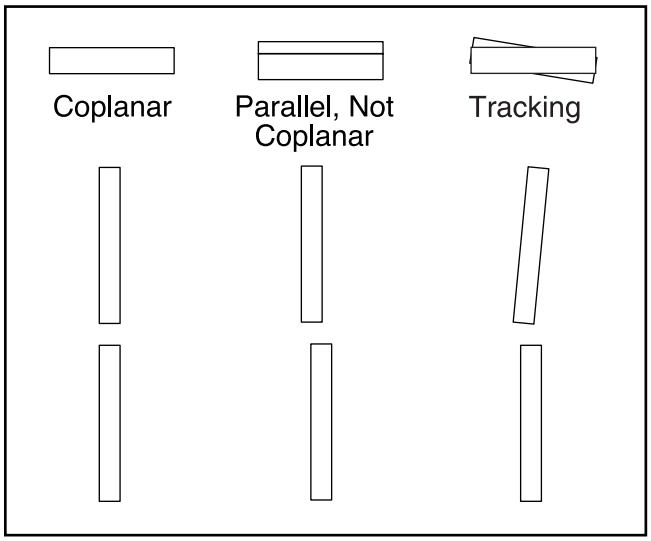
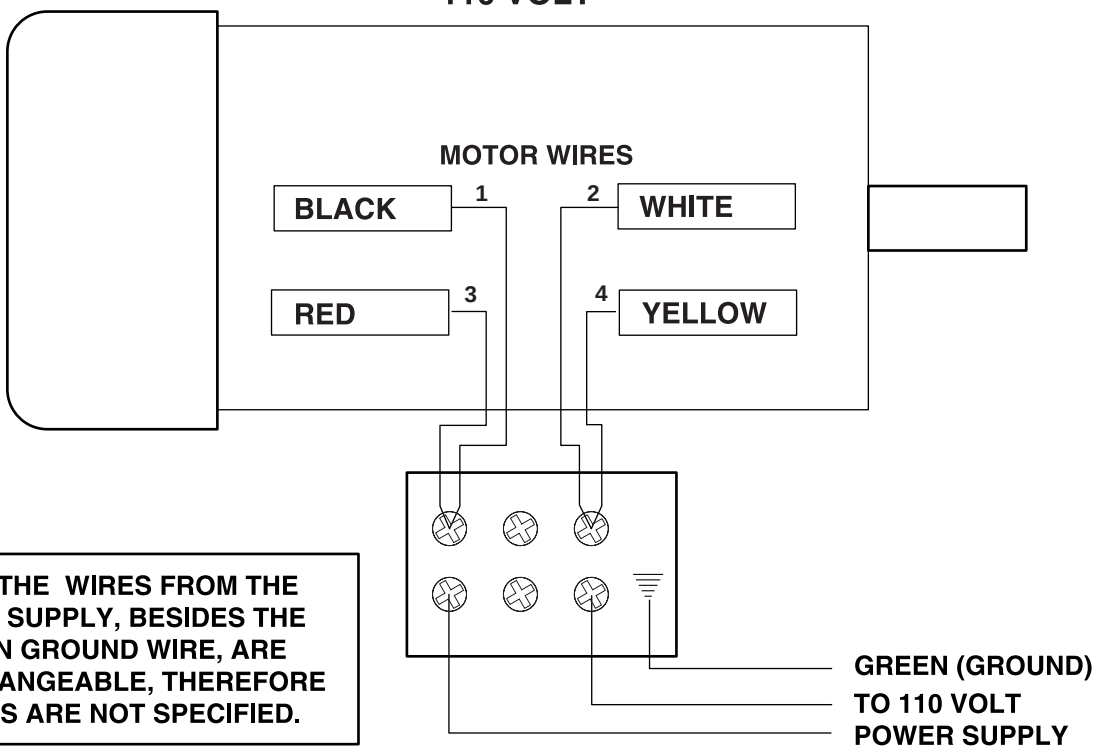


Figure 44. Coplanar diagram.

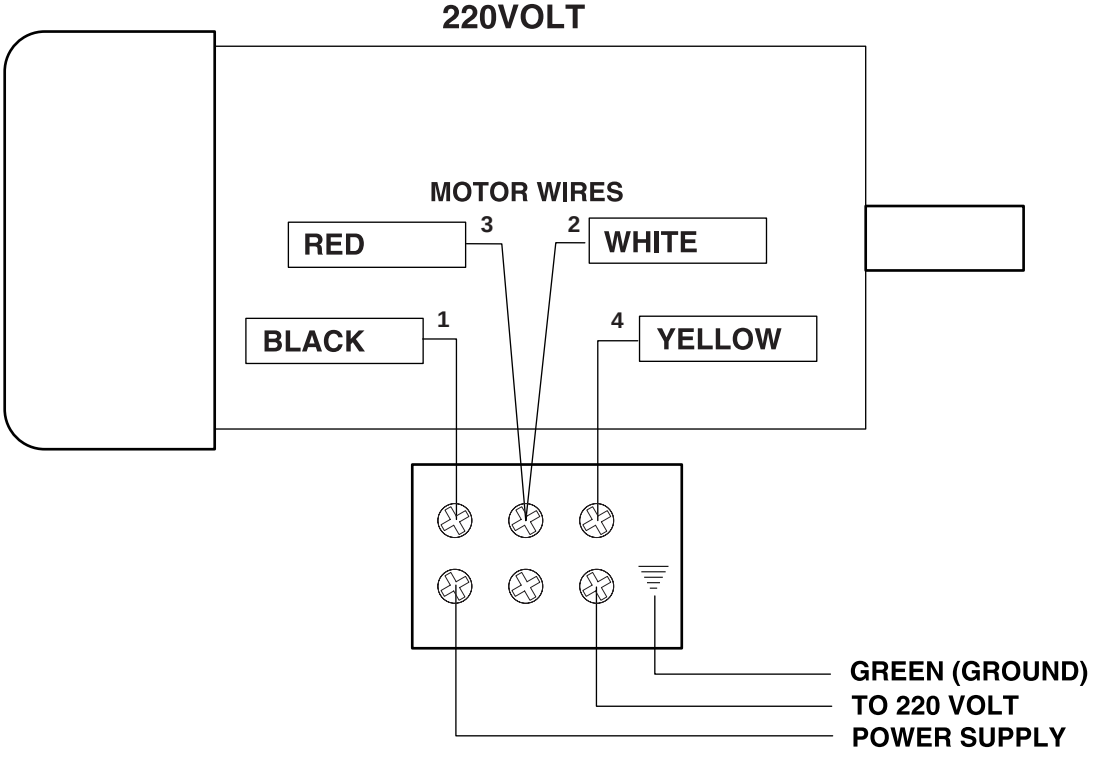
MODEL G0555
WIRING DIAGRAM

110 VOLT



NOTE: THE WIRES FROM THE POWER SUPPLY, BESIDES THE GREEN GROUND WIRE, ARE INTERCHANGEABLE, THEREFORE COLORS ARE NOT SPECIFIED.

220VOLT



Troubleshooting

Motor will not start.	**1.** Low voltage. **2.** Open circuit in motor or loose connections.	**1.** Check power line for proper voltage. **2.** Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	**1.** Short circuit in line cord or plug. **2.** Short circuit in motor or loose connections. **3.** Circuit Overloaded.	**1.** Inspect cord or plug for damaged insulation and shorted wires. **2.** Inspect all connections on motor for loose or shorted terminals or worn insulation. **3.** Reduce load on circuit.
Motor fails to develop full power (power output of motor decreases rapidly with decrease in voltage at motor terminals).	**1.** Power line overloaded with lights, appliances, and other motors. **2.** Undersized wires or circuits too long. **3.** General overloading of power company facilities.	**1.** Reduce load on power line. **2.** Increase wire sizes or reduce length of wire. **3.** Request a power check from the power company.
Motor overheats.	**1.** Motor overloaded. **2.** Air circulation through the motor restricted.	**1.** Reduce load on motor. **2.** Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	**1.** Short circuit in motor or loose connections. **2.** Low voltage. **3.** Incorrect fuses or circuit breakers in power line. **4.** Motor overloaded.	**1.** Inspect connections on motor for loose or shorted terminals or worn insulation. **2** Correct the low voltage conditions. **3.** Install correct fuses or circuit breakers. **4.** Reduce load on motor.
Machine slows when operating.	Applying too much pressure to workpiece.	Feed workpiece slower.
Blade does not run evenly on wheels or runs off.	**1.** Tracking is not adjusted properly. **2.** Wheels are not coplanar.	**1.** Adjust tracking. **2.** Adjust wheel alignment.
Blade does not cut evenly.	**1.** Blade is not properly tensioned. **2.** Wheels are not coplanar. **3.** Tooth set is uneven. **4.** Teeth are sharper on one side than the other.	**1.** Adjust blade tension. **2.** Adjust wheel alignment. **3.** Skew fence to compensate or replace blade. **4.** Skew fence to compensate or replace blade.
Blade slows when cutting. Blade makes a squealing noise, especially on start-up.	**1.** V-belt loose. **2.** V-belt worn out.	**1.** Tighten V-belt. **2.** Replace V-belt.
Ticking sound when the saw is running.	Weld contacting thrust bearing.	Use the G2516 Stone to smooth and round the back of the blade.
Blade contacting table insert.	**1.** Excessive side pressure when cutting. **2.** Table improperly adjusted. **3.** Opening in insert too narrow.	**1.** Reduce side pressure. **2.** Adjust table. **3.** File opening in table insert larger.
Excessive vibration.	**1.** Rubber pads not installed under stand. **2.** Wheels not coplanar. **3.** Tires incorrectly installed. **4.** Worn out V-belt. **5.** Bent or worn out blade. **6.** Wheels out of balance.	**1.** Install rubber pads under stand. **2.** Adjust wheel alignment. **3.** Re-install tires. **4.** Replace V-belt. **5.** Replace blade. **6.** Replace wheels.

SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your Model G0555 14" Bandsaw.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the **General Information** section. The specifications, drawings, and photographs illustrated in this manual represent the Model G0555 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered *as they apply to your specific situation.*

⚠WARNING

Operating this equipment has the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to your machine, or if you need general assistance or replacement parts, please contact the Service Department listed in the **General Information** section.

Additional information sources are necessary to realize the full potential of your machine. Trade journals, woodworking magazines, and your local library are good places to start.

⚠WARNING

Like all power tools, there is danger associated with the Model G0555 14" Bandsaw. Use the tool with respect and caution to lessen the possibility of mechanical damage or operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠WARNING

The Model G0555 was specifically designed for wood cutting operations. DO NOT MODIFY AND/OR USE THIS BANDSAW FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, DO NOT use it until all your questions are answered. Serious personal injury may occur.

Grizzly Industrial, Inc.®

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0555 ULTIMATE 14" BANDSAW

Design Type ..... Floor Model

Overall Dimensions:

Table Size ..... 14" x 14" x 1½"
Height From Floor To Table ..... 43⅝"
Overall Height ..... 66½"
Overall Width ..... 26⅜"
Overall Depth ..... 30¼"
Shipping Weight ..... 176 lbs.
Machine Weight ..... 167 lbs.
Box Size ..... 43½"L x 20 11/16"W x 17⅝"H
Footprint ..... 24½"W x 17½"D

Capacities:

Throat Capacity (Left of Blade) ..... 13½"
Height Capacity ..... 6"
Table Tilt ..... 10˚L, 45˚R
Blade Size Range ..... ⅛"-¾"
Standard Blade Length ..... 92½"
Blade Speeds ..... 1500, 3200 FPM

Construction:

Table ..... Precision Ground Cast Iron
Wheels ..... Fully Balanced Cast Aluminum w/Rubber Tires
Rip Fence ..... Deluxe Extruded Aluminum Fence
Wheel Covers ..... Pre-Formed Steel
Guides ..... Anti-Collision Design, Ball Bearing Blade Guides
Stand ..... Pre-Formed Steel

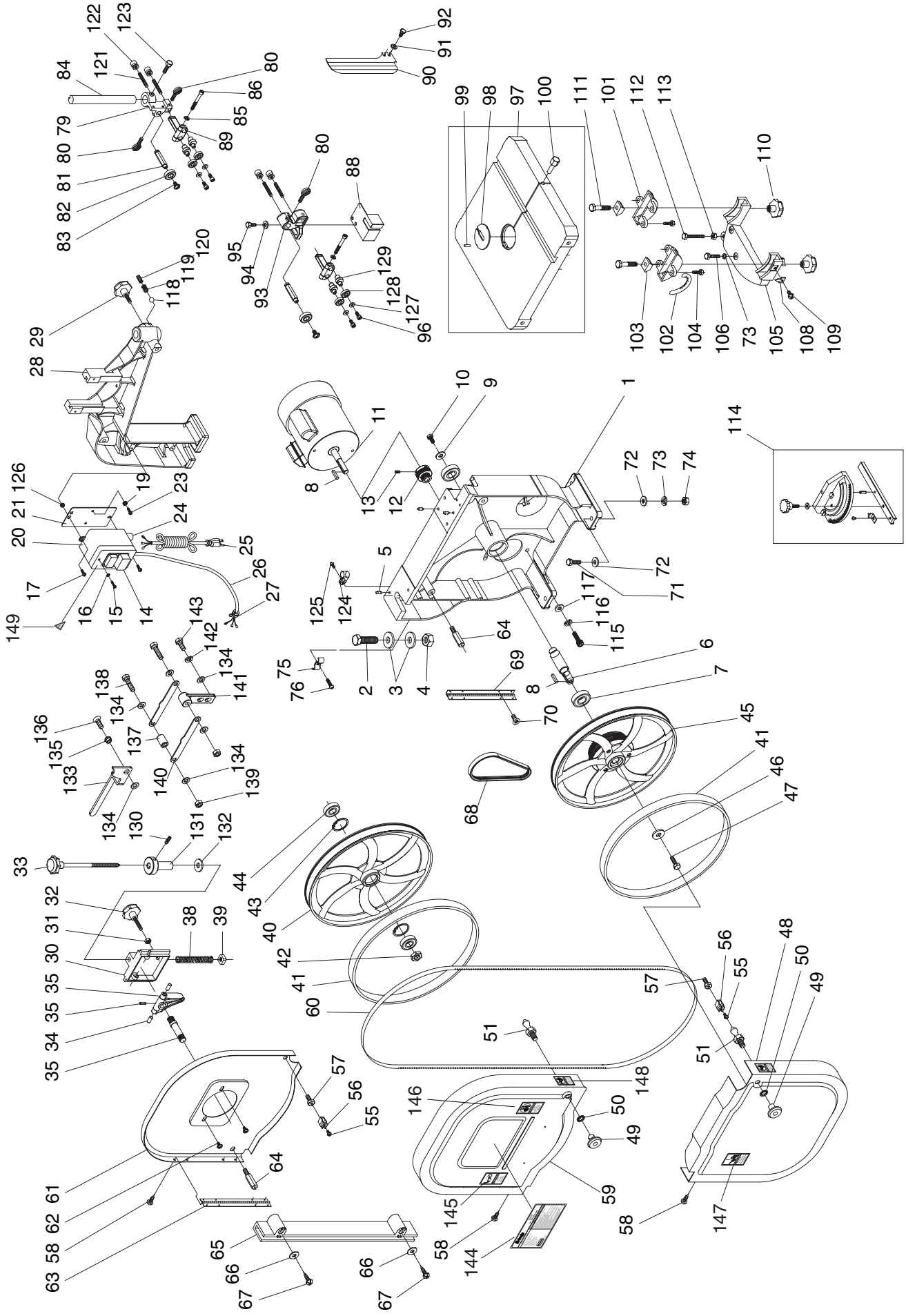
Main Motor:

Type ..... TEFC Capacitor-Start Induction
Horsepower ..... 1 HP
Phase / Voltage ..... Single-Phase / 110/220V
Amps 10/5A
Cycle / RPM ..... 60 Hertz / 1725 RPM
Switch ..... ON/OFF Push Button
Bearings ..... Shielded & Lubricated Ball Bearings

Features:

..... 4" Dust Port
..... Magnifying Window Over Fence Scale
..... Hinged Wheel Covers
..... Powder Coated Paint
..... 6" Riser Block Available (Model H3051)

Specifications, while deemed accurate, are not guaranteed.

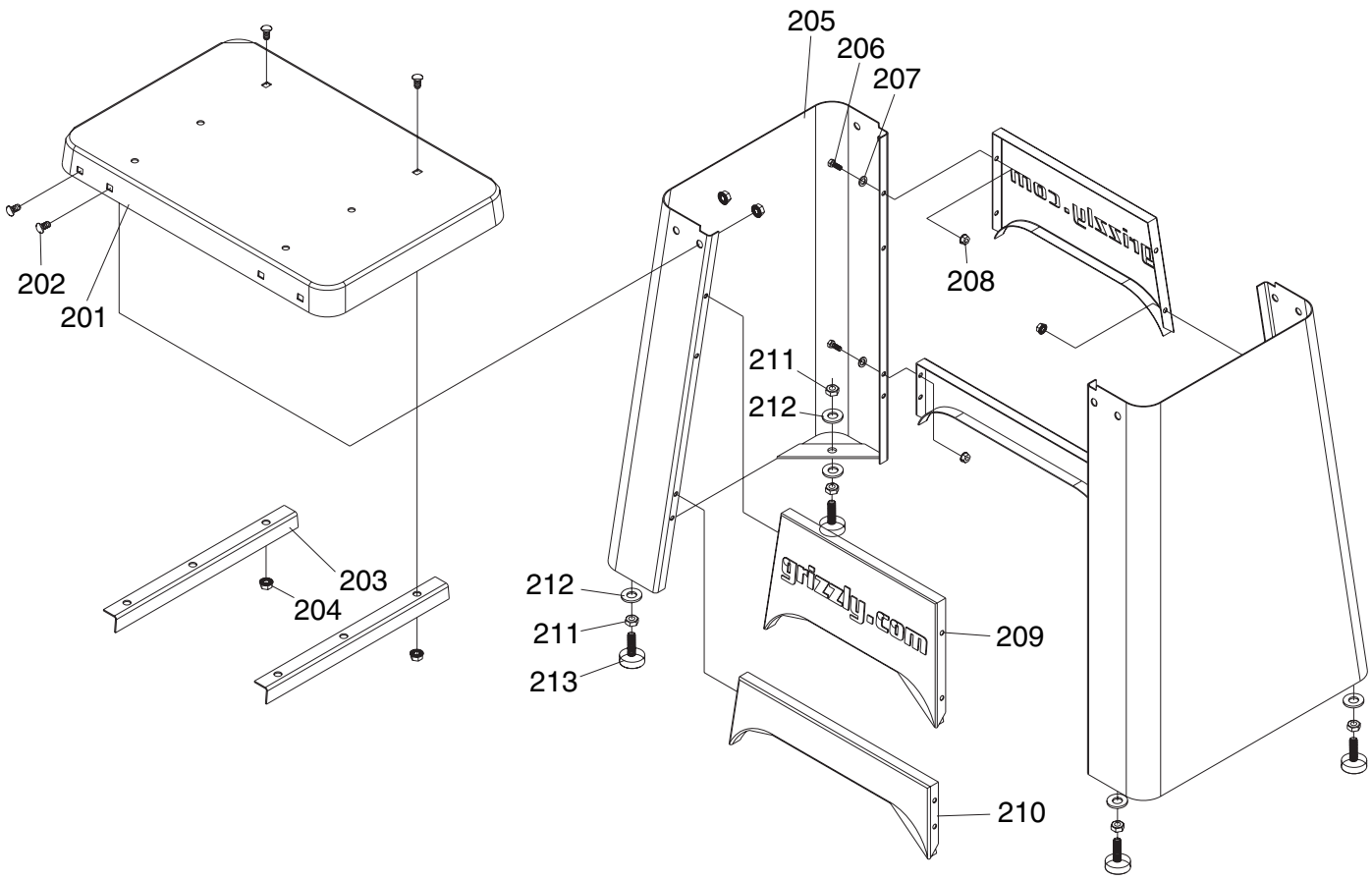


REF	PART #	DESCRIPTION
1	P0555001	BASE
2	PB80M	HEX BOLT M16-2.0 X 55
3	PW08M	FLAT WASHER 16MM
4	PN13M	HEX NUT M16-2.0
5	P0555005	PIN
6	P0555006	LOWER WHEEL SHAFT
7	P6204	BEARING 6204ZZ
8	PK23M	KEY 5 X 5 X 25
9	PW01M	FLAT WASHER 8MM
10	PS16M	PHLP HD SCR M8-1..25 X 16
11	P0555011	MOTOR 1 HP
12	P0555012	MOTOR PULLEY
13	PSS11M	SETSCREW M6-1.0 X 16
14	P0555014	SWITCH (PUSH BUTTON)
15	PHTEK1M	TAP SCREW M3.5 X 12 (AB)
16	PW05M	FLAT WASHER 5MM
17	PS40M	PHLP HD SCR M5-.8 X 16
19	PTLW02M	EXT TOOTH WASHER M5
20	P0555020	SWITCH ENCLOSURE
21	P0555021	SWITCH PLATE
23	PS19M	PHLP HD SCR M5-.8 X 6
24	P0555024	STRAIN RELIEF
25	P0555025	POWER CORD
26	P0555026	MOTOR CORD
27	P0555027	STRAIN RELIEF
28	P0555028	UPPER FRAME ARM
29	P0555029	KNOB BOLT M10-1.5 X 25
30	P0555030	UPPER WHEEL BRACKET
31	PN03M	HEX NUT M8-1.25
32	P0555032	KNOB BOLT M8-1.25 X 45
33	P0555033	TENSION KNOB BOLT
34	P0555034	STEEL PIN
35	P0555035	UPPER WHEEL HINGE
38	P0555038	COIL SPRING
39	P0555039	SQUARE NUT M10-1.5

REF	PART #	DESCRIPTION
40	P0555040	UPPER WHEEL
41	P0555041	WHEEL TIRE
42	PN24M	HEX NUT M12-1.25
43	PR21M	INT RETAINING RING 35MM
44	P6202	BEARING 6202ZZ
45	P0555045	LOWER WHEEL
46	PW01M	FLAT WASHER 8MM
47	PB81M	HEX BOLT M8-1.25 X 20 (LH)
48	P0555048	LOWER WHEEL GUARD
49	P0555049	KNOB M8-1.25
50	PTLW03M	INT TOOTH WASHER 8MM
51	P0555051	STUD LATCH
55	PS08M	PHLP HD SCR M5-.8 X 12
56	P0555056	CATCH
57	P0555057	LOCATING BOLT
58	PHTEK4M	TAP SCREW M4 X 8
59	P0555059	COVER- UPPER FRONT
60	P0555060	SAW BLADE
61	P0555061	COVER- UPPER BACK
62	PFS01M	FLANGE SCREW M5-.8 X 8
63	P0555063	UPPER HINGE
64	P0555064	STUD
65	P0555065	SAW BLADE GUARD
66	P0555066	GASKET
67	PHTEK2M	TAP SCREW M3.5 X 16 (AB)
68	P0555068	BELT 200J5
69	P0555069	LOWER HINGE
70	PFH07M	FLAT HD SCR M5-.8 X 10
71	PB20M	HEX BOLT M8-1.25 X 35
72	PW01M	FLAT WASHER 8MM
73	PLW04M	LOCK WASHER 8MM
74	PN03M	HEX NUT M8-1.25
75	P0555075	CORD CLAMP
76	PS08M	PHLP HD SCR M5-.8 X 12
79	P0555079	GUIDE SUPPORT BRACKET

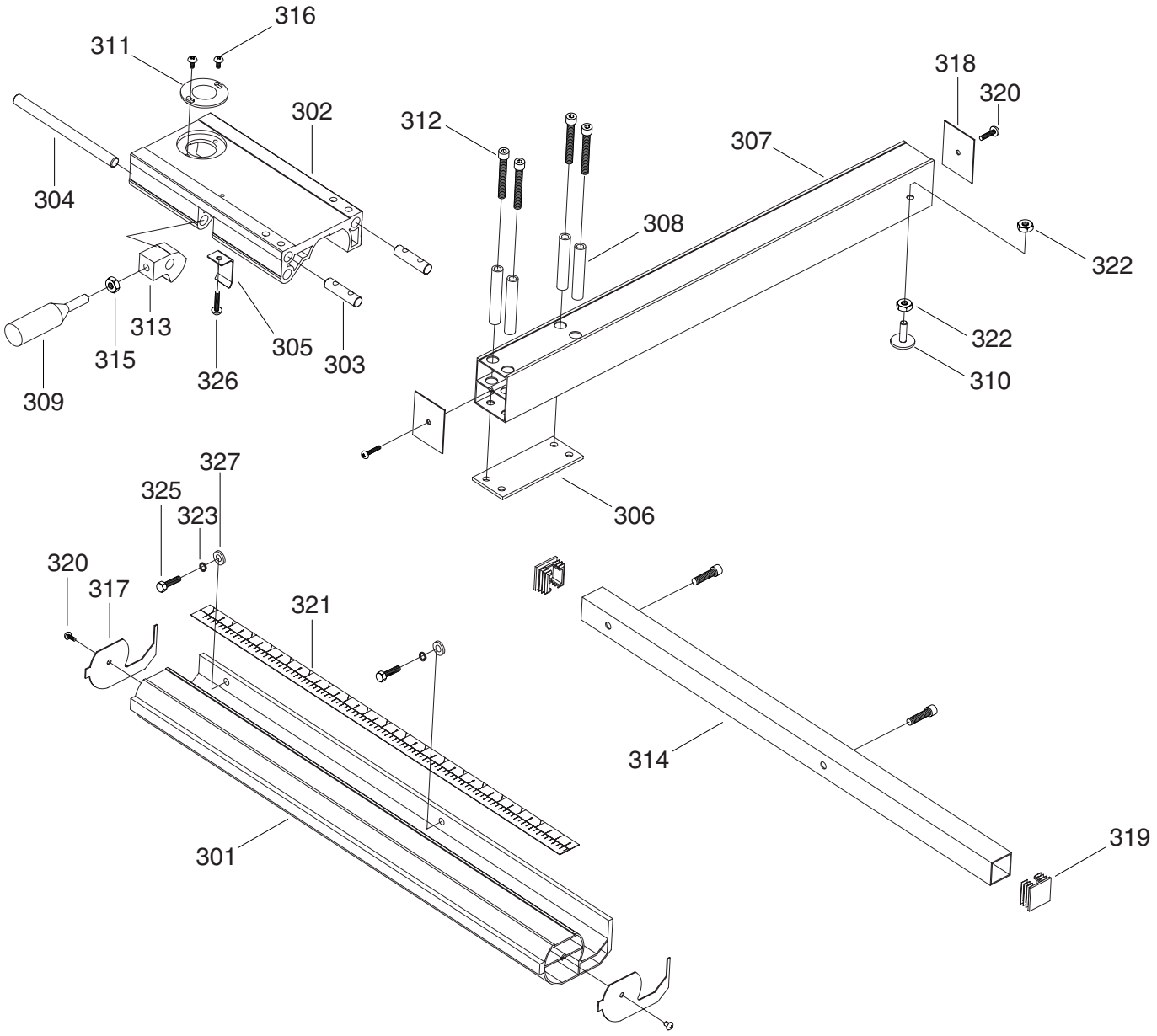
REF	PART #	DESCRIPTION
80	PTS001M	THUMB SCREW M6-1.0 X 16
81	P0555081	UPPER SPACING SLEEVE
82	P6200ZZ	BALL BEARING 6200ZZ
83	PFS02M	FLANGE SCREW M6-1.0 X 12
84	P0555084	GUIDE POST
85	PLW01M	LOCK WASHER 5MM
86	PSB78M	CAP SCREW M5-.8 X 40
88	P0555088	LOWER BLADE GUARD
89	P0555089	SUPPORT BRACKET
90	P0555090	BLADE GUARD (L)
91	PW03M	FLAT WASHER 6MM
92	PB04M	HEX BOLT M6-1.0 X 10
93	P0555093	LOWER BRACKET POST
94	PW03M	FLAT WASHER 6MM
95	PB08M	HEX BOLT M6-1.0 X 20
96	PSB33M	CAP SCREW M5-.8 X 12
97	P0555097	TABLE
98	P0555098	TABLE INSERT
99	P0555099	SPRING PIN 3 X 8
100	P0555100	TABLE PIN
101	P0555101	TRUNNION
102	P0555102	SCALE
103	P0555103	TRUNNION CLAMP SHOE
104	PB02M	HEX BOLT M6-1.0 X 12
105	P0555105	TRUNNION SUPPORT
106	PB26M	HEX BOLT M8-1.25 X 30
108	P0555108	POINTER
109	PFS03M	FLANGE SCREW M5-.8 X 6
110	P0555110	KNOB M10-1.5
111	PB73M	HEX BOLT M10-1.5 X 50
112	PB82M	HEX BOLT M8-1.25 x 80
113	PN03M	HEX NUT M8-1.25
114	P0555114	MITER GAUGE
115	PSB31M	CAP SCREW M8-1.25 X 25

REF	PART #	DESCRIPTION
116	PLW04M	LOCK WASHER 8MM
117	PW01M	FLAT WASHER 8MM
118	P0555118	STEEL BALL
119	P0555119	SPRING
120	PSS43M	SETSCREW M10-1.5 X 10
121	PSS44M	SETSCREW M8-1.25 X 40
122	P0555122	MICRO ADJUSTING NUT
123	PB83M	HEX BOLT M6-1.0 X 16
124	P0555124	CORD CLAMP
125	PS08M	PHLP HD SCR M5-.8 X 12
126	PLN01M	LOCK NUT M4-.7
127	PW02M	FLAT WASHER 5MM
128	P608ZZ	BEARING 608ZZ
129	P0555129	BIAS SHAFT
130	PSS03M	SETSCREW M6-1.0 X 8
131	P0555131	FIXED LUMP
132	PW04M	FLAT WASHER 10MM
133	P0555133	LEVER ROD
134	PW01M	FLAT WASHER 8MM
135	P0555135	BUSHING
136	PSB82M	BUTTON CAP SCREW M8-1.25 X 20
137	P0555137	BRACKET
138	PB15M	HEX BOLT M8-1.25 X 40
139	P0555139	NYLON NUT M8-1.25
140	P0555140	SUPPORT PLATE
141	P0555141	FIXED BASE
142	PLW04M	LOCK WASHER 8MM
143	PB09M	HEX BOLT M8-1.25 X 20
144	P0555144	G0555 ID/WARNING LABEL
145	PLABEL-11	SAFETY GLASSES LABEL
146	PLABEL-20	DO NOT OPEN LABEL
147	PLABEL-18	UNPLUG BANDSAW LABEL
148	PLABEL-23	HAND/BS BLADE LABEL
149	PLABEL-14	ELECTRICITY LABEL



REF	PART #	DESCRIPTION
201	P0555201	STAND TOP
202	PCB06M	CARRIAGE BOLT M8-1.25 X 16
203	P0555203	STAND TOP BRACE
204	PFN01M	FLANGE NUT M8-1.25
205	P0555205	STAND SIDE
206	PB83M	HEX BOLT M6-1.0 X 16
207	PW03M	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
208	PFN02M	FLANGE NUT M6-1.0
209	P0555209	UPPER STAND BRACE
210	P0555210	LOWER STAND BRACE
211	PN08	HEX NUT ⅜"-16
212	PW04M	FLAT WASHER 10MM
213	P0555213	STAND FOOT



REF	PART #	DESCRIPTION
301	P0555301	LARGE FENCE RAIL
302	P0555302	ADJUSTABLE BASE
303	P0555303	FIXED SHAFT
304	P0555304	SHAFT
305	P0555305	SPRING PIECE
306	P0555306	BRACKET
307	P0555307	SUPPORT TUBE
308	P0555308	INTERVAL SHEATH
309	P0555309	HANDLE
310	P0555310	ADJUSTABLE RUNNER
311	P0555311	CONVEX WINDOW
312	PSB83M	CAP SCREW M6-1.0 X 55
313	P0555313	LOCK MECHANISM
314	P0555314	SMALL FENCE RAIL

REF	PART #	DESCRIPTION
315	PN01M	HEX NUT M6-1.0
316	PFS04M	FLANGE SCREW M4-.7 X 6
317	P0555317	LARGE RAIL CAP
318	P0555318	FENCE CAP
319	P0555319	SMALL RAIL CAP
320	PHTEK3M	TAP SCREW M3.5 X 8
321	P0555321	SCALE
322	PN01M	HEX NUT M6-1.0
323	PLW03M	LOCK WASHER 6MM
324	PSB01M	CAP SCREW M6-1.0 X 16
325	PB08M	HEX BOLT M6-1.0 X 20
326	PFS05M	FLANGE SCREW M4-.7 X 10
327	PW03M	FLAT WASHER 6MM

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

WARRANTY CARD

Name _____

Street _____

City _____State_____Zip_____

Phone Number_____E-Mail_____FAX_____

MODEL# _____ **SERIAL#**_____Order #_____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?

___Advertisement
___Catalog
___World Wide Web
___Friend
___Card Deck
___Other_____

2. Which of the following magazines do you subscribe to.

___American Woodworker
___Cabinetmaker
___Family Handyman
___Fine Homebuilding
___Fine Woodworking
___Home Handyman
___Journal of Light Construction
___Old House Journal
___Popular Mechanics
___Popular Science
___Popular Woodworking
___Other_____
___Practical Homeowner
___Shop Notes
___Today's Homeowner
___WOOD
___Wooden Boat
___Woodshop News
___Woodsmith
___Woodwork
___Woodworker
___Woodworker's Journal
___Workbench

3. Which of the following woodworking/remodeling shows do you watch?

___Backyard America
___Home Time
___The American Woodworker
___Other_____
___The New Yankee Workshop
___This Old House
___Woodwright's Shop

4. What is your annual household income?

___$20,000-$29,999
___$30,000-$39,999
___$40,000-$49,999
___$50,000-$59,999
___$60,000-$69,999
___$70,000-$79,999
___$80,000-$89,999
___$90,000 +

5. What is your age group?

___20-29
___30-39
___40-49
___50-59
___60-69
___70 +

6. How long have you been a woodworker?

___0 - 2 Years
___2 - 8 Years
___8 - 20 Years
___20+ Years

7. How would you rank your woodworking skills?

___Simple
___Intermediate
___Advanced
___Master Craftsman

8. What stationary woodworking tools do you own? Check all that apply.

___Air Compressor
___Band Saw
___Drill Press
___Drum Sander
___Dust Collector
___Horizontal Boring Machine
___Jointer
___Lathe
___Mortiser
___Panel Saw
___Planer
___Power Feeder
___Radial Arm Saw
___Shaper
___Spindle Sander
___Table Saw
___Vacuum Veneer Press
___Wide Belt Sander
___Other_____

9. How many of your woodworking machines are Grizzly? _____

10. Which benchtop tools do you own? Check all that apply.

___1" x 42" Belt Sander
___5" - 8" Drill Press
___8" Table Saw
___8" - 10" Bandsaw
___Disc/Belt Sander
___Mini Jointer
___6" - 8" Grinder
___Mini Lathe
___10" - 12" Thickness Planer
___Scroll Saw
___Spindle/Belt Sander
___Other_____

11. How many of the machines checked above are Grizzly? _____

12. Which portable/hand held power tools do you own? Check all that apply.

___Belt Sander
___Biscuit Joiner
___Circular Saw
___Detail Sander
___Drill/Driver
___Miter Saw
___Other_____
___Orbital Sander
___Palm Sander
___Portable Planer
___Saber Saw
___Reciprocating Saw
___Router

13. What machines/supplies would you like Grizzly Industrial to carry?

_____
_____
_____
_____
_____
_____

14. What new accessories would you like Grizzly Industrial to carry?

_____
_____
_____

15. What other companies do you purchase your tools and supplies from?

_____
_____
_____

16. Do you think your purchase represents good value?

___Yes ___No

17. Would you recommend Grizzly Industrial to a friend?

___Yes ___No

18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**

___Yes ___No

19. Comments:_____
_____
_____
_____
_____
_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE